

Date: Thursday, 5/10/2007 2:30:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 32296		
Estimate Number	: 12775		
P.O. Number	: <i>N/A</i>	Part Number	: D350600241
This Issue	: 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: IIN REV.C PG11,18-21
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: E, C
Previous Run	: 32295	Material	: <i>NA</i>
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature] 07.05.10</i>		
Comment	: Est Rev: A 07.03.07 new issue ec est rev B 07.04.16 reformat,D3188 revE ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-241 CHG001

C2

07.05.11

[Signature]

2.0	32296A	SPACEPOD BODY LH
-----	--------	------------------



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: _____

w/o 30019

ml 07/06/20

3.0	32296B	SPACEPOD DOOR LH
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Comment: Sub-Component SPACEPOD DOOR LH

D3186-3 32296B w/o 30009

ml 07/06/20

4.0	D31871	Spacepod Floor
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1 ✓ Floor ~~B 32296A~~ B31835

1 D3186-3 ✓ Door (ref) ~~B 32296B~~

1 D3188-1m Body(ref) ~~B31835~~ B32296A B30019

✓

ml 07/06/20

5.0	ALS41032130	Insert
-----	-------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: *M1102475*

[Signature] 07/06/200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

1104760

8/24/06/20 @

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

N/A used new floor already painted
use jig DT8970 4# E

2-Open holes in D3188-1 body floor to Ø0.297".

OK

3-Install inserts in D3188-1 as per Dwg D3188. OK

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187.

N/A

5-Deburr holes in D3187-1

N/A

ml07/06/25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/3 07/06/25 (1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

E

N/A ml07/06/25

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

E

N/A ml07/06/25

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E

N/A ml07/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: B30632 ^{+5.9010}
118000

✓ ml 07/06/28

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/06/28

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2706-28

n/a
ml 07/06/25

15.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B30169 -

ep

16.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B30120 -

ep

17.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: B31127 -

ep

18.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
BATCH: M103641 -

ep

ep 07/06/200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D2237	Striker Plate
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: B31692 -

ep

20.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Batch: M3459 -

ep

21.0	D35381	HINGE BRACKET
------	--------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HINGE BRACKET
batch: B32371 -

ep

22.0	D2179	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: B30630 -

ep

23.0	AN526C832R24	screw
------	--------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
batch: M104603 -

ep

24.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M104156 -

ep

25.0	MS21042L08	-Nut-
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: M104721 (24) - M104812 X2

ep

ep 7/16/20 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

this step separates hardware, previous steps is for body & floor

ml 07/06/25

27.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: *M103585*

epb

28.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: *M104156*

epb

29.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: *M100993*

epb

30.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: *M104812 x 2*

ml 07/06/25

31.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: *B30681*

epb

32.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: *B31127*

epb

ep 5-10-06/200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D2586	Door Latch
------	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: B30880 -

ep

34.0	D2585	Latch Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Clamp
batch: B30814 -

ep

35.0	D2621	Latch Plate
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate
batch: B31111 -

ep

36.0	MS27039115	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M15432 -

ep

37.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: M104118 -

ep

38.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M103691 -

ep

39.0	D28571	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: B31832 -

ep

ep 5/10/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	D28572	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: B30718

ep

41.0	D2228	Backing Plate
------	-------	---------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Backing Plate
batch: B30679

ep

42.0	AN526C832R10	Screw
------	--------------	-------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M103585

ep

43.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M104156

ep

44.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
batch: M104812 X12

✓

m107/06/25

45.0	D35571	BRACKET
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B31126

ep

46.0	AN526C832R14	Screw
------	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M19216

ep

ep 07/06/2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585-

07/06/2008

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: M104835 expire date: 17 May 2008

A/R Milled fibres batch: M100859

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: M102565

PTD 07/06/28

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M104733

M-L 07/06/28

51.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

52.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

53.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

B 32369

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-241 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 07.07.19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/28	4/8.A	Bad installation of foam on floor. R.C: Human error upon installation.	<u>AS/1412</u>	Scrap foam. Clean floor and Re-do installation.	<u>ml</u> 07/06/28	<u>070719.</u>	<u>AS/1412</u>	<u>Aug 28</u>

NOTE: Date & initial all entries

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 32296

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

54.0 D2985 Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label B31116 X

SP

55.0 D35471 BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B32372 X

SP

56.0 D35501 STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STRUT
batch: B32450 X

SP

57.0 D35527 CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CARBON STEEL GAS SPRING
batch: B32644 X

SP

58.0 D35547 BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B30210 X

SP

59.0 AN960JD516 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: A103694 X

SP

60.0 D30153 Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B22365 X

7/7/5 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2/7/18 *07/07/18* *1*

62.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP Rev: _____

B *07/15* *1*
FINAL INSPECTION/W/O RELEASE

63.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19

Job Completion



U *07.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

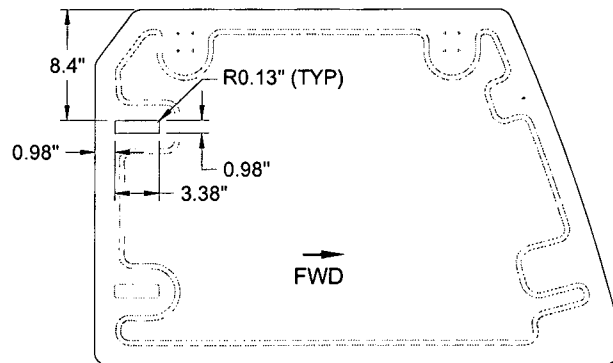


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

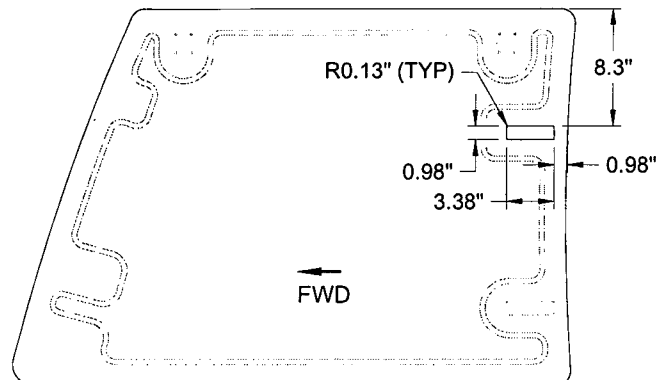


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

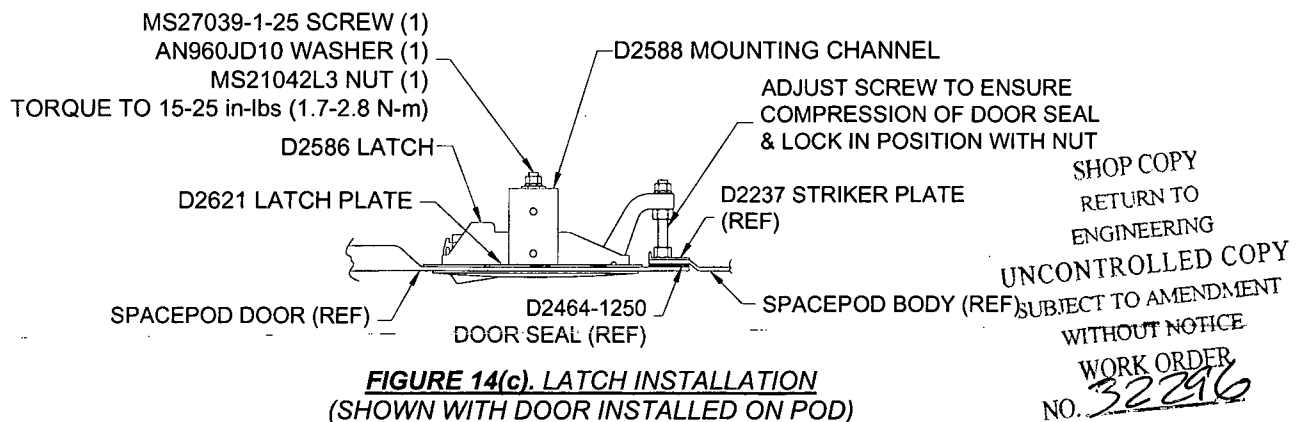


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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Revision: **C**
Date: 07.02.20

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

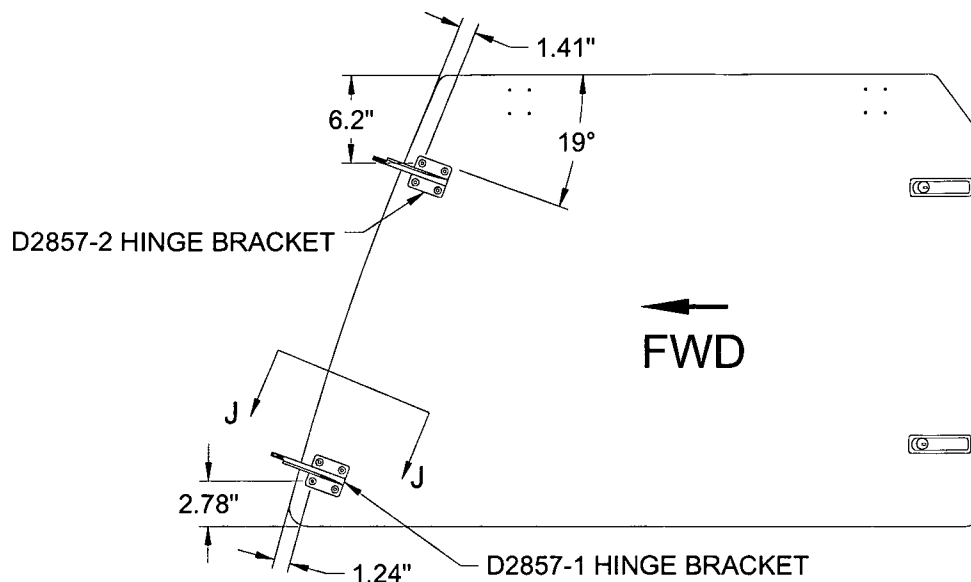


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

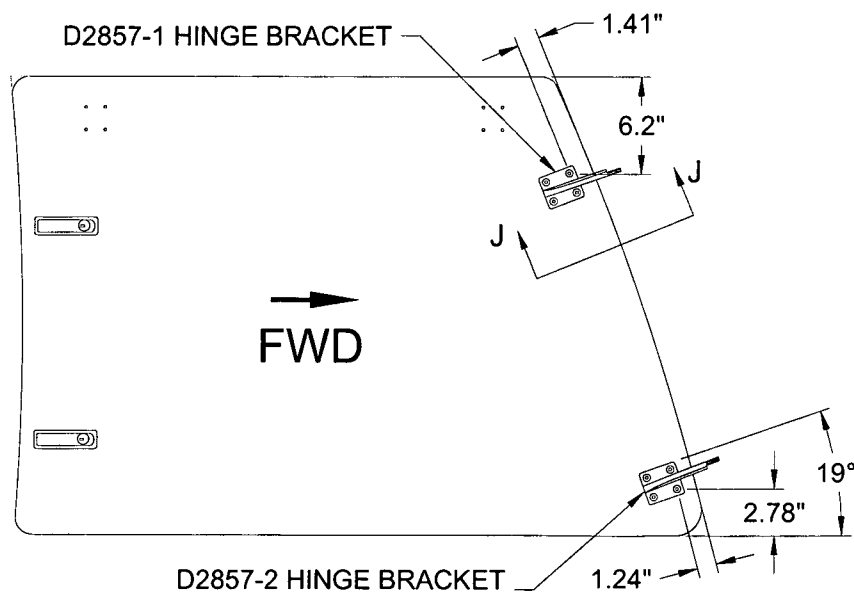


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32296

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

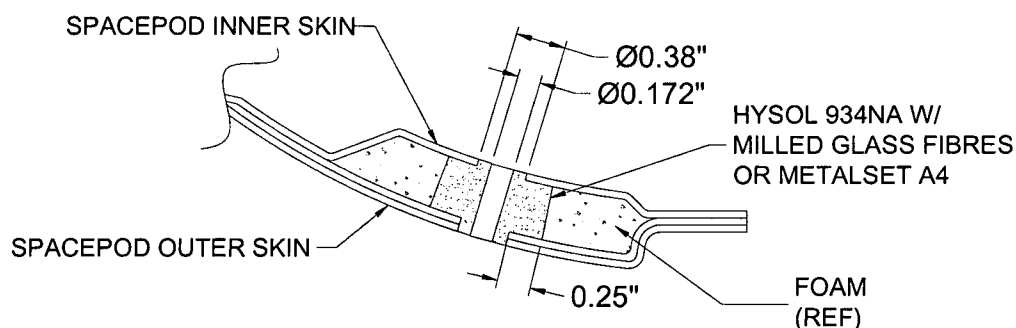


FIGURE 17(a). COMPOSITE MODIFICATION

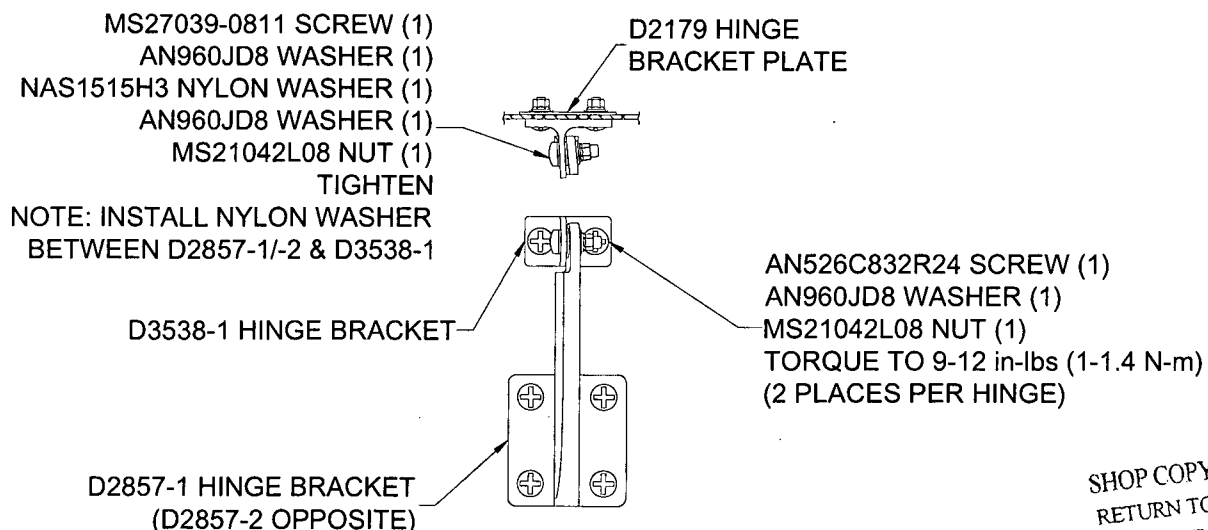


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1-SHOWN; D2857-2-OPPOSITE)

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WORK ORDER
NO. 32296

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 32296B		
Estimate Number	: 12635		
P.O. Number	:	Part Number	: D31863
This Issue	: 5/10/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 32295B	Material	:
Written By	: _____	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: _____ <i>[Signature]</i> 07.05.10		
Comment	: Est Rev.A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

w/o 30009

[illegible]

D3186-1m

[illegible][illegible][illegible]

ml07/06/20^{x1}

[illegible][illegible]

SB 07/06/20 (1)

[illegible][illegible]

Location: GA

mul 07/06/20^{x1}



07.07.19

[illegible]

W 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

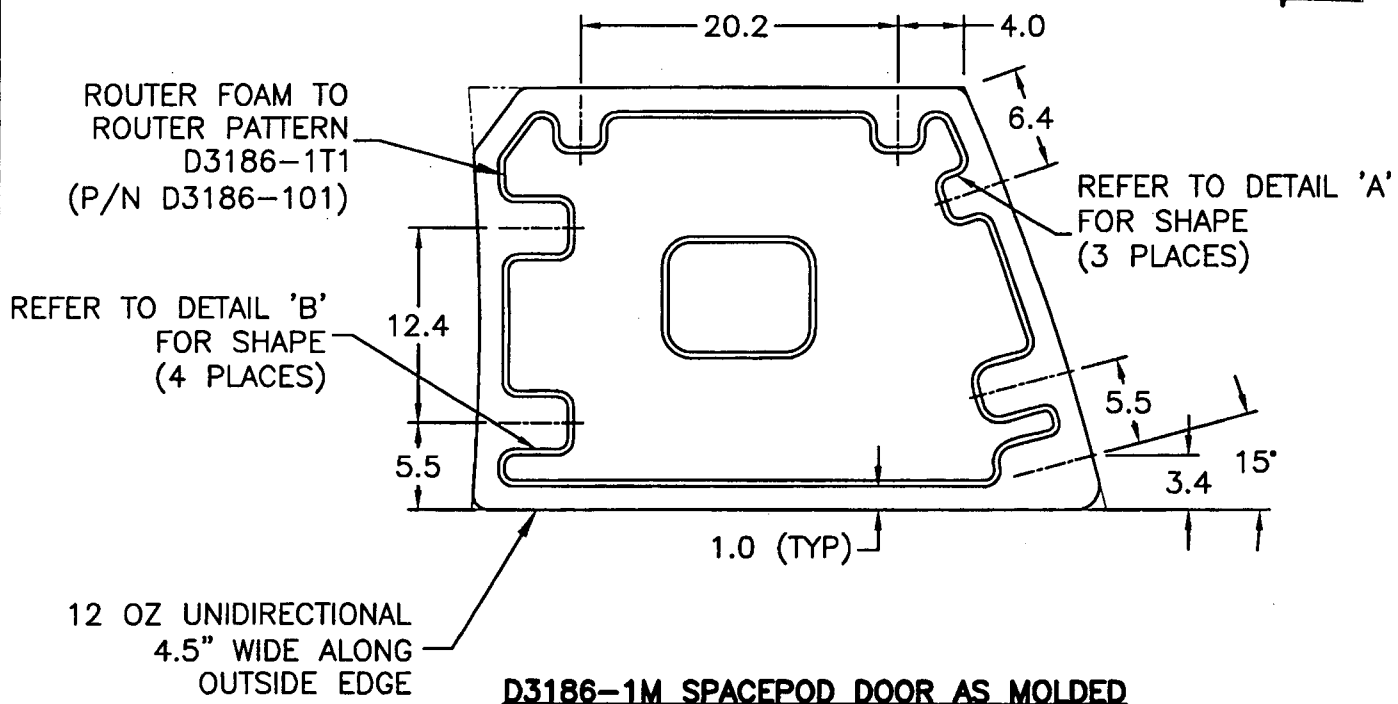
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *H***NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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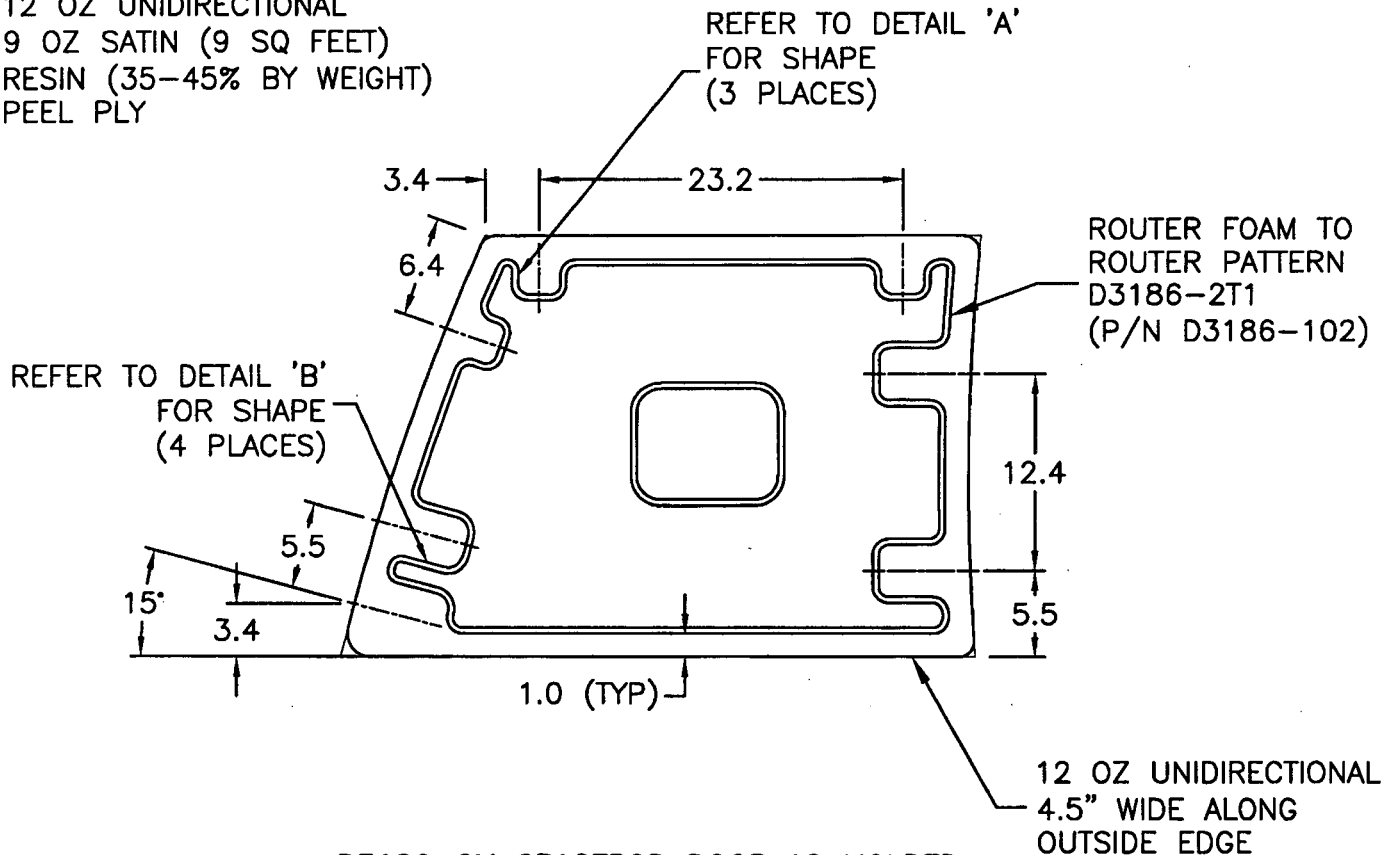
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
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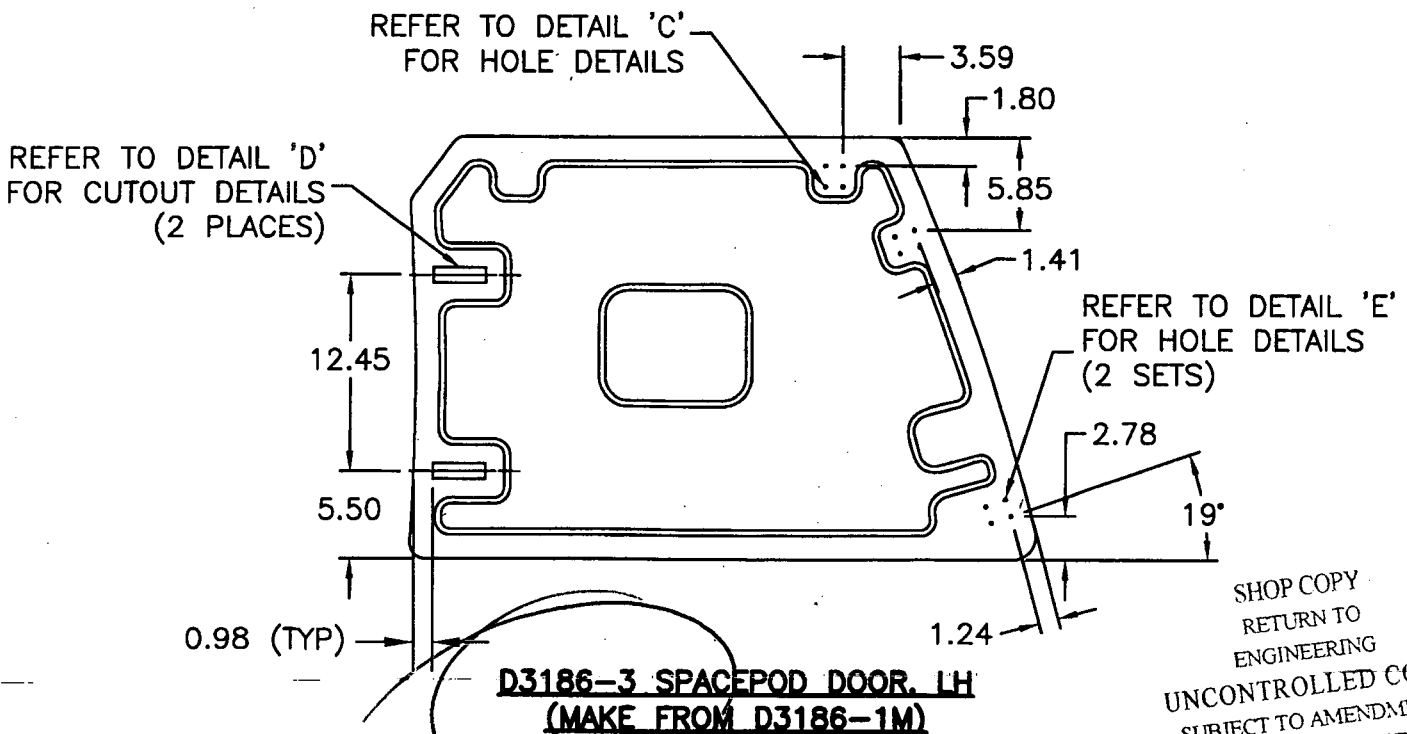
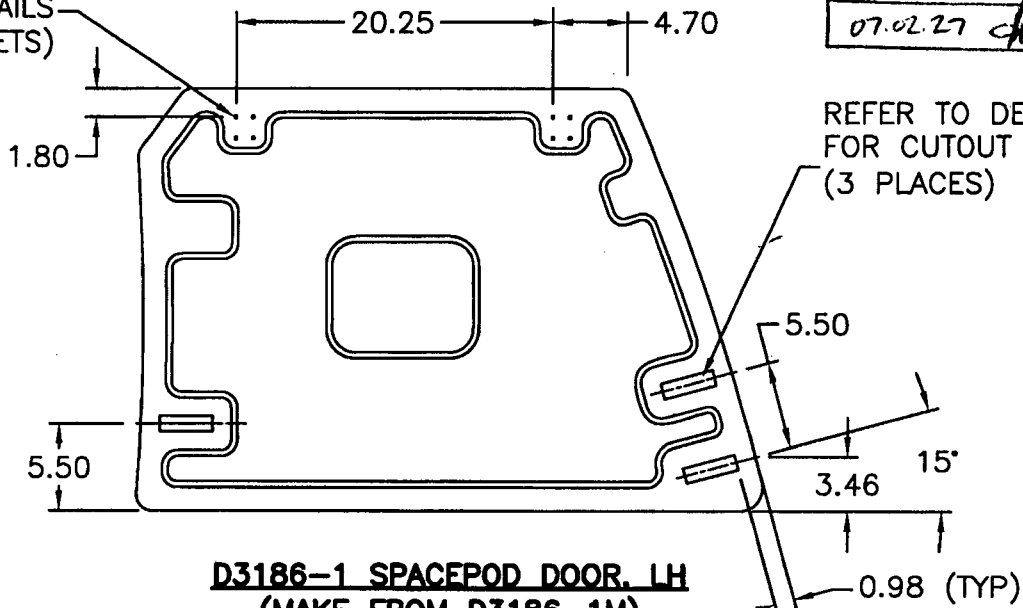
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
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(2 SETS)

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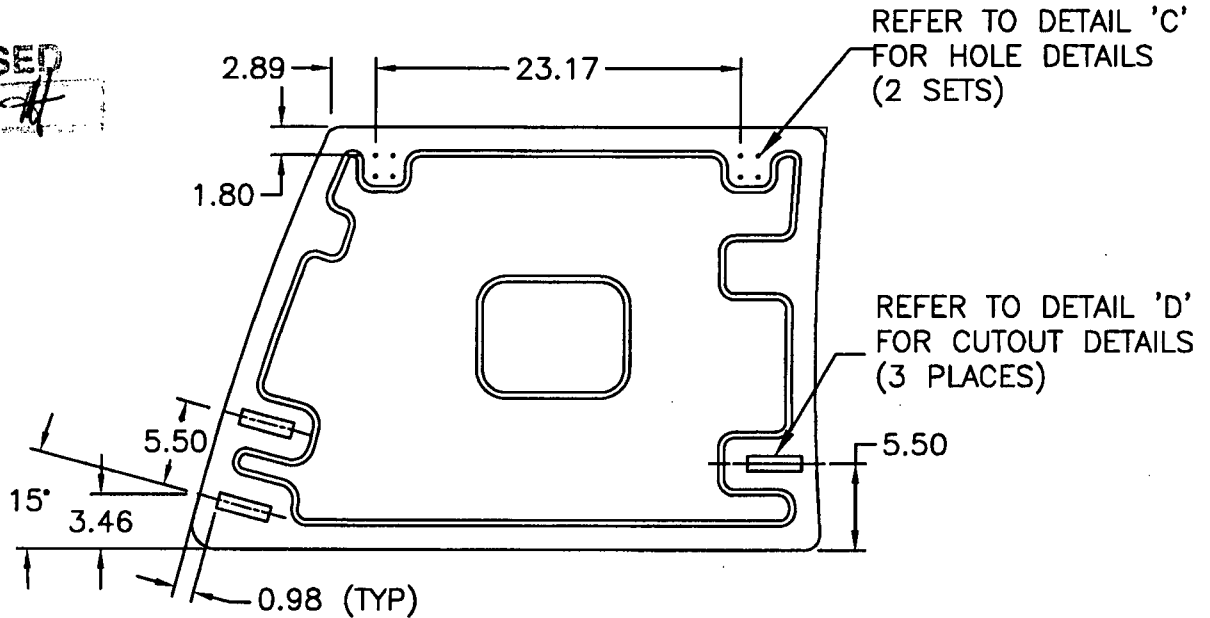
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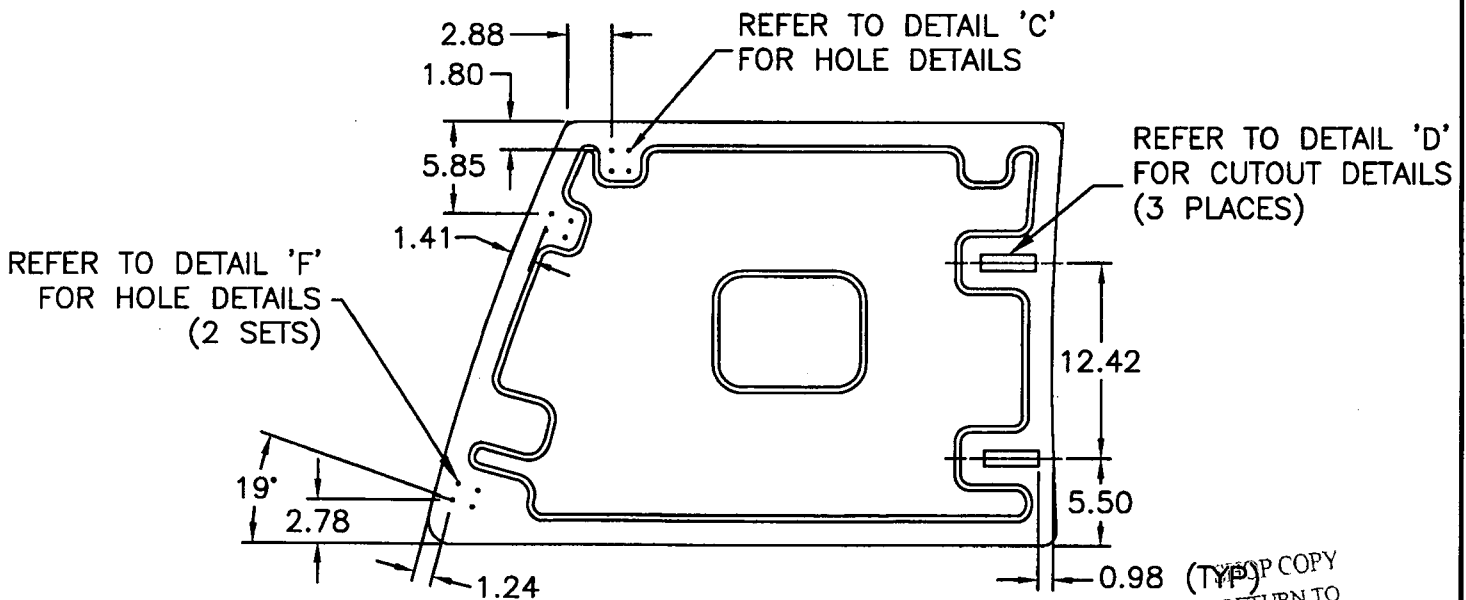
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

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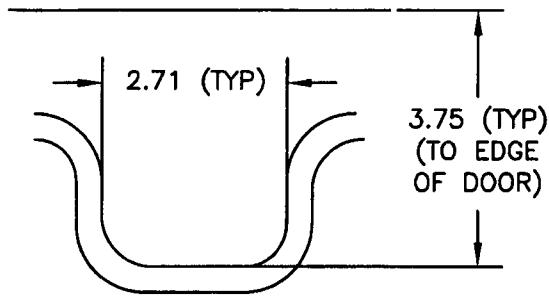
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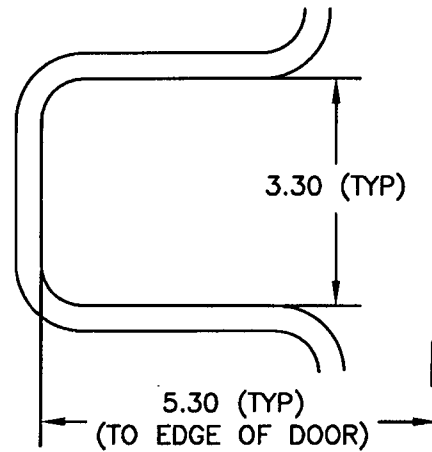
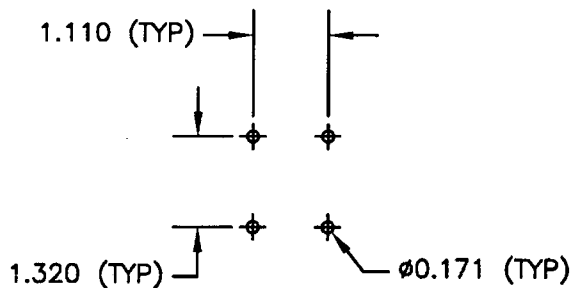
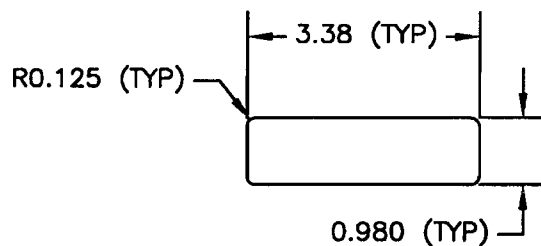
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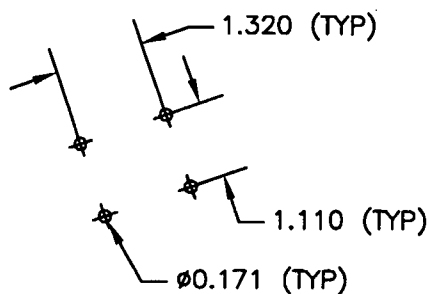
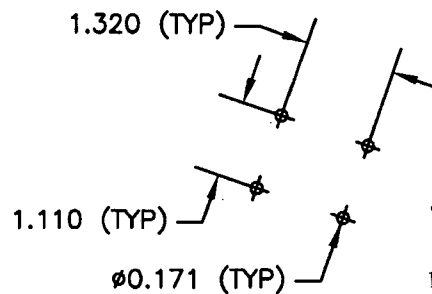
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F**

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Date: Wednesday, 12/20/2006 1:44:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR LH
 Job Number : 30009
 Estimate Number : 12598
 P.O. Number :
 This Issue : 12/20/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D31861M
 Drawing Number : D3186 REV *BC* *UG* *07.01.18*
 First Issue : 11 Type : PURCHASED PARTS Project Number : N/A
 Drawing Revision : *BC* *UG* *07.01.18*
 Previous Run : Material :
 Due Date : 1/15/2007 Qty: 1 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06-12-20
 Comment : Est Rev: A New Issue 06-12-04 ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

CLoc/12/21
(1)

2.0 D31861 *PG* Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

07/06/180

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

ml 07/6/20

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: *GA*

ml 07/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30009

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12.07.19

Job Completion



U 12.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

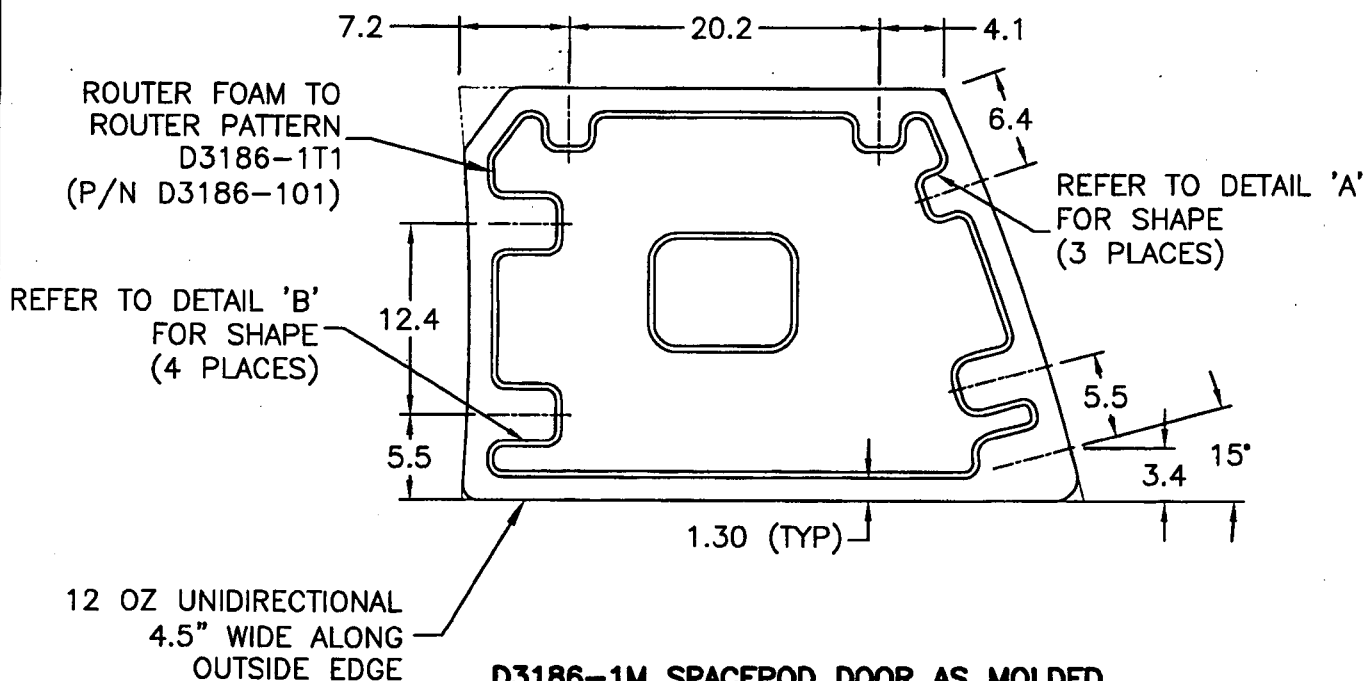
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**
06.12.22 H**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
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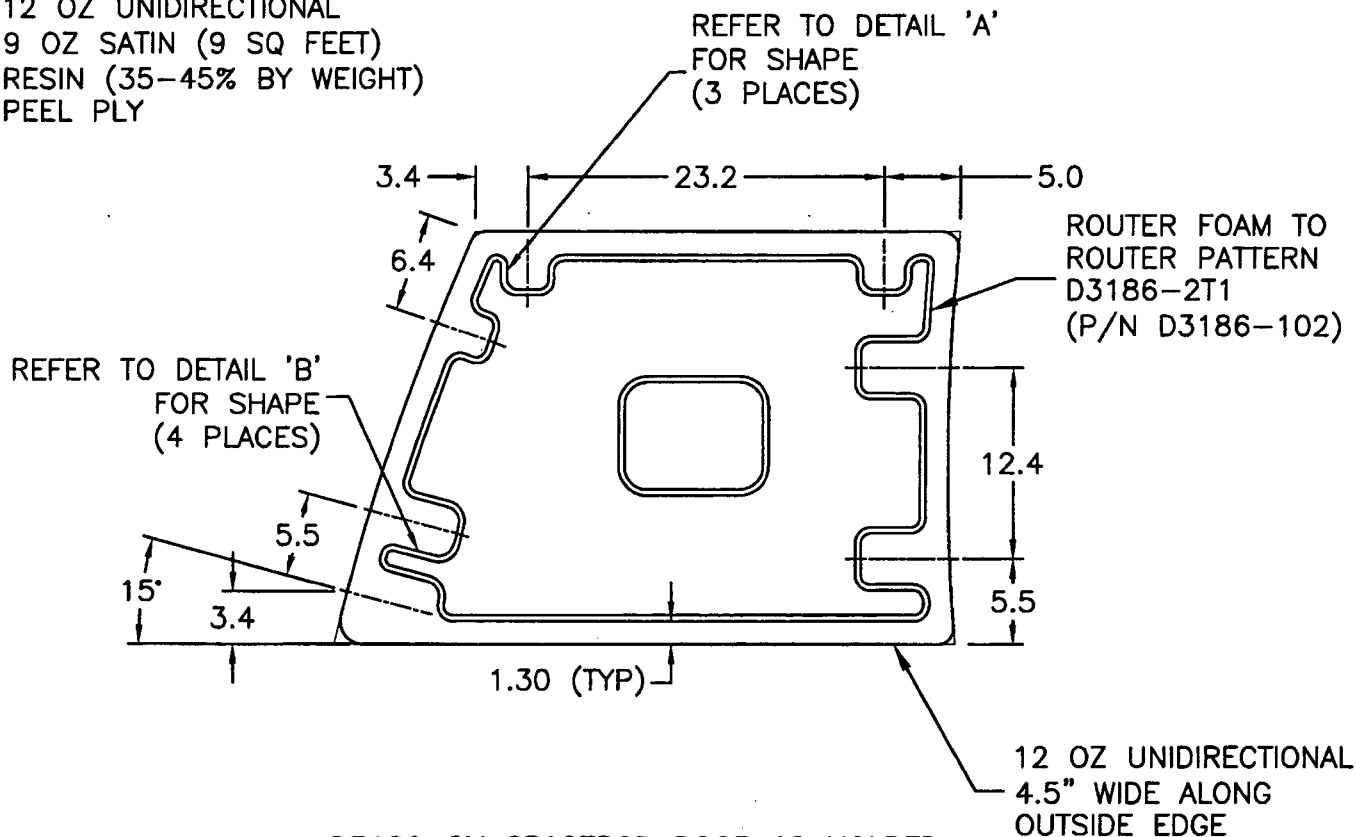
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
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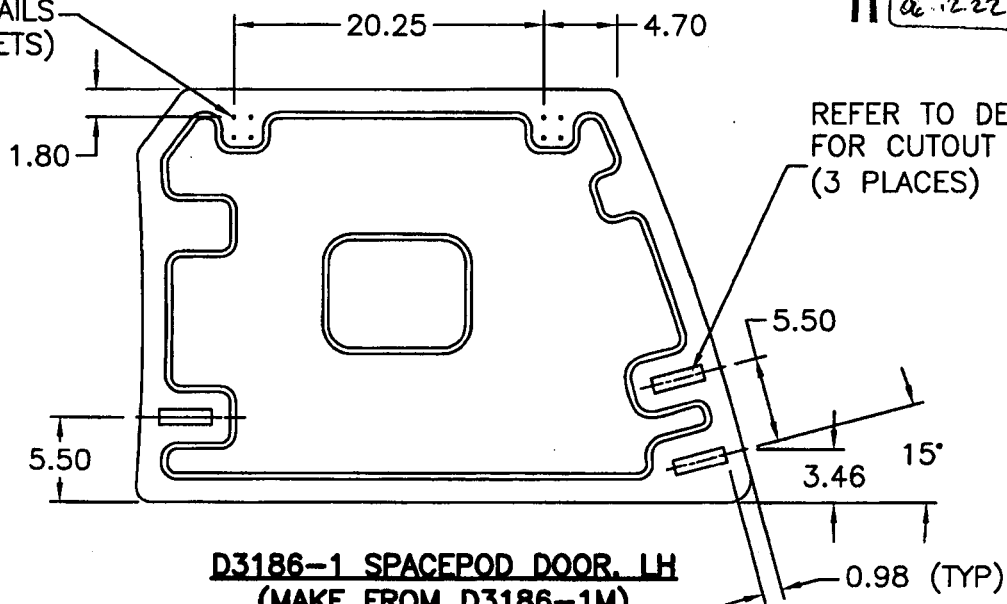
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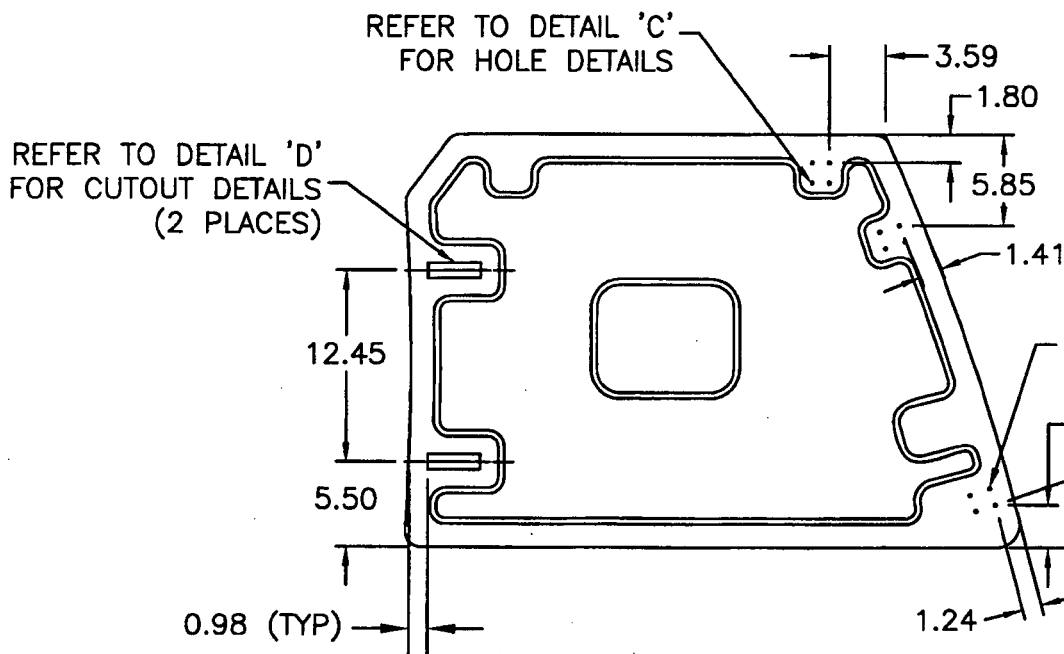


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



RELEASED
06.12.22



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

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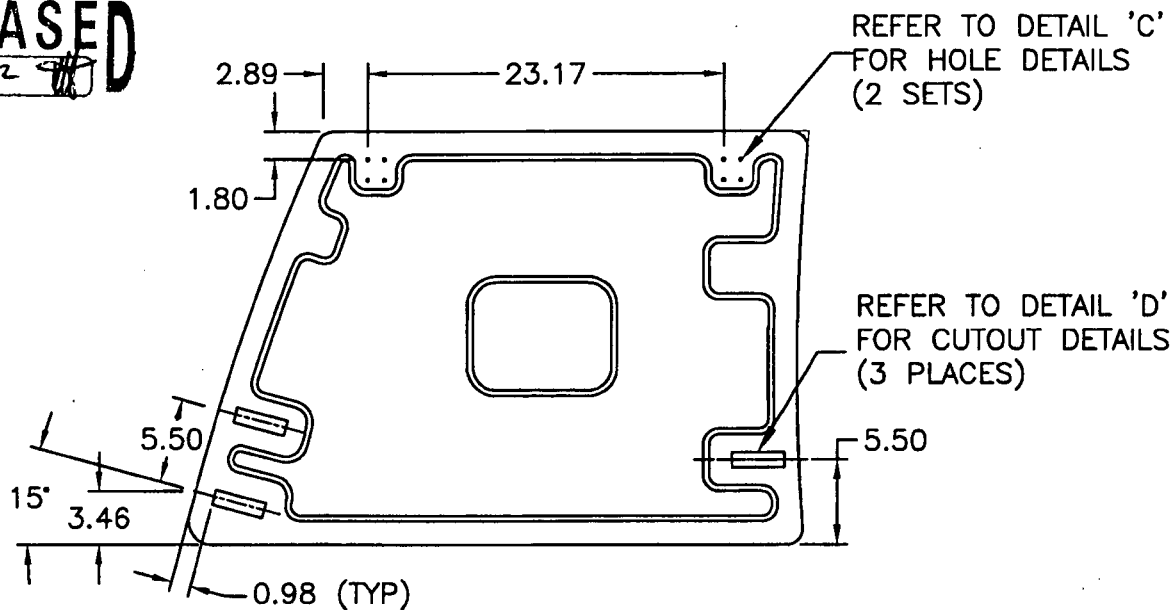
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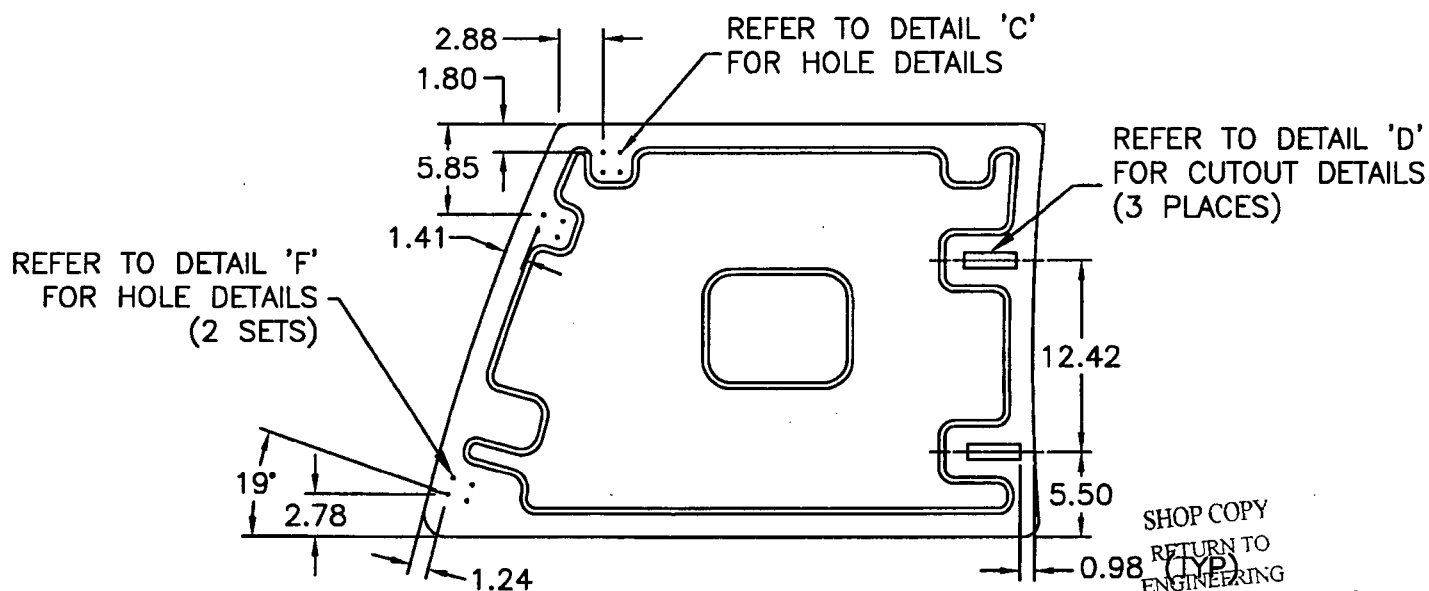


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
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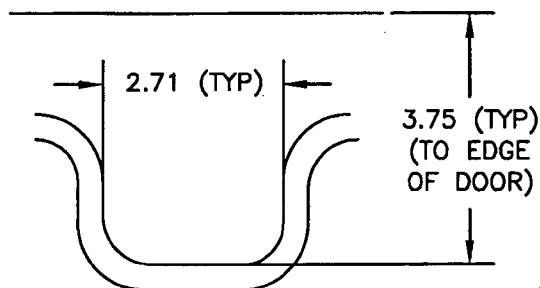
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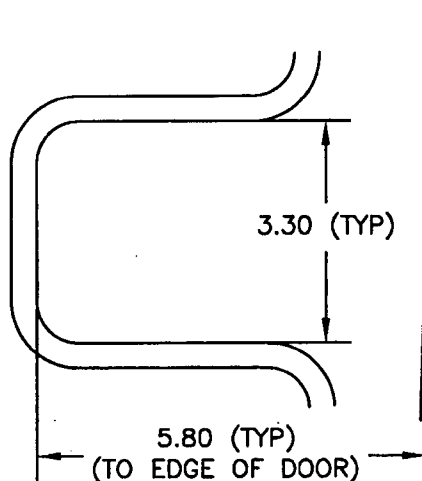
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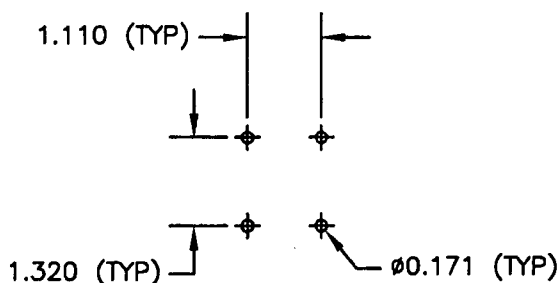
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



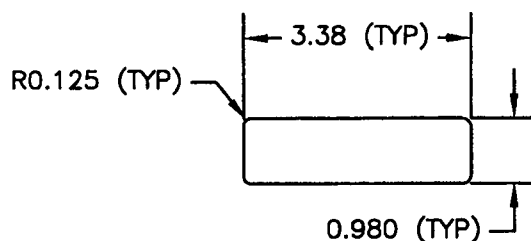
DETAIL A



DETAIL B

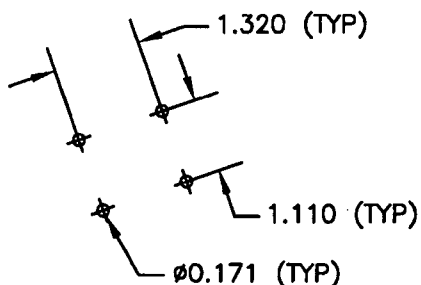


DETAIL C

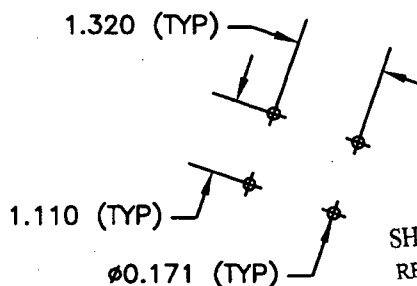


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RELEASED
NO. 3000-9

DELASTEK COMPOSITES

DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788
Warehouse: MAIN

Invoice #	12007
Customer #	DART

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/06/2007	21/12/2006	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30039 Dwg. Rév.: D Job: 41311			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30009 Dwg. Rév.: C Job: 41320 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30019 Dwg. Rév.: D Job: 41302 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30029 Dwg. Rév.: D Job: 41330 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.


Accepted by:

[Signature]
Quality department
AQ-357



Date: Jeudi, 2007-03-29 10:33:51
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD DOOR
Numéro Job :	41320	Numéro Article :	DKC134-0052
Numéro Soumission :	2584	Numéro Dessin :	D3186
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-03-29	Révision dessin :	C
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	- -	Date Dûe :	2007-04-05
Job précédente :	41319	Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31861M		

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
----------------	------------------------------	----------------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------


Commentair	Qty.: 0.020 GALLON(s)/Unit	Total : 0.020 GALLON(s)
	Frekote 44NC	

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair	Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
	PRÉPARATION DU MOULE	

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: MAY 18 2007 Heure Début: 2:00 Heure Fin: 4:30 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair	Qty.: 3.28 VERGE(s)/Unit	Total : 3.28 VERGE(s)
	Tissu à délaminer Release ply B	

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair	Qty.: 3.59 VERGE(s)/Unit	Total : 3.59 VERGE(s)
	Wrightlon 5200 Bleu P3	

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair	Qty.: 3.00 VERGE(s)/Unit	Total : 3.00 VERGE(s)
	Feutre de drainage N° Airweave N 10	

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair	Qty.: 3.00 VERGE(s)/Unit	Total : 3.00 VERGE(s)
	Stretchlon 200 poche à vide Vert	

Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT 1-6083-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 1/05/07 Heure Début: 8:00 Heure Fin: 9:00 Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6148-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

MAY 22 2007

Date: _____ Heure Début: 11:10 Heure Fin: 11:15 Sceau:



Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: MAY 22 2007

Heure Début: 11:15

Heure Fin: 11:30

Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: MAY 22 2007

Heure Début: 11:30

Heure Fin: 11:35

Sceau:



Curing Début: 11:15 Curing Fin: 8:00

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6148-1

Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

MAY 23 2007

Date:

Heure Début

11:30

Heure Fin

11:45

Sceau:



19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)
------	-------------	--

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-101 (Porte D3186-1)

LOT 1-5826-1

20.0	AAC0452	Polybond B46F
------	---------	---------------

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot:

1-6666-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
------	--------------	--------------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

MAY 28 2007

Date:

Heure Début

12:30

Heure Fin

1:00

Sceau:



22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: MAY 28 2007 Heure Début: 1:00 Heure Fin: 1:10 Sceau:



Curing Début: 12:30 Curing Fin: 1:45

23.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6148-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: MAY 29 2007 Heure Début: 2:00 Heure Fin: 2:05 Sceau:



26.0

LAMINAGE.

LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le lamination d'un pli de 9.7 oz.

Faire le lamination du pli de tissu de 12 oz tout le tour de la porte .

Faire le lamination du dernier pli de 9.7 oz.

Date: MAY 29 2007 Heure Début: 2:05 Heure Fin: 2:50 Sceau:



Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE

Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

MAY 29 2007

Date:

Heure Début:

2:50

Heure Fin:

3:00

Sceau:



Curing Début:

2:05

Curing Fin:

8:00

28.0 DÉMOLAGE 1 DÉMOLAGE PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOLAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date:

30/05/07

Heure Début:

8:00

Heure Fin:

8:05

Sceau:

REPARER
RVC: C1266

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date:

01-6-07

Heure Début:

8:05

Heure Fin:

8:40

Sceau:



-- 30.0 -- AAC0671:

Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S 1-6149-1

Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S

1-6065-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

1-5092-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyages qty 1 04-06-07

JUN 04 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DARTAppliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

JUN 04 2007

Date: Heure Début: Heure Fin: Sceau:



35.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé



Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total: 0.050 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6079-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 06-07-07 Heure Début: 2:35 Heure Fin: 4:20 Sceau:



40.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6049-1

41.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6065-1

42.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5092-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIEL

MASQUAGE + Nettoyage Qty: 1 07-06-07

MASQUAGE + nettoyage 08-06-07

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

JUN 07 2007



JUN 08 2007



44.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs

APPLICATION DE PRIMER

JUN 08 2007



Appliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #
Application du primer

JUN 07 2007

Date: Heure Début: Heure Fin: Sceau:



Date: Jeudi, 2007-03-29 10:33:51

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41320

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

INSPECTION PIÈCE DART

Qty: 1 11/06/07



N.S.

Emballage QT 1

11/06/07



Date: Wednesday, 12/20/2006 1:44:48 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY LH
Job Number :	30019		
Estimate Number :	12595		
P.O. Number :		Part Number :	D31881M
This Issue :	12/20/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3188 REV <i>PC LE 07-01-18</i>
First Issue :	11	Project Number :	N/A
Previous Run :		Drawing Revision :	<i>PC LE 07-01-18</i>
	Type :	Material :	
	PURCHASED PARTS	Due Date :	1/15/2007
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<i>JA 061220</i>		
Comment :	Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch: *B25325 C207101102 ⑧*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
Issue P/O: *2767*
Description: D3188-1M BODY *C206112121 ①*
Ship: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0	D31881 <i>M</i>	Spacepod Body
-----	-----------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

JA 061180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30019

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/06/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/06/20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107.07.09

Job Completion



U 07.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
JB	LE	DRAWING NO.	REV. C
CHECKED PH	APPROVED PH	D3188	SHEET 1 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

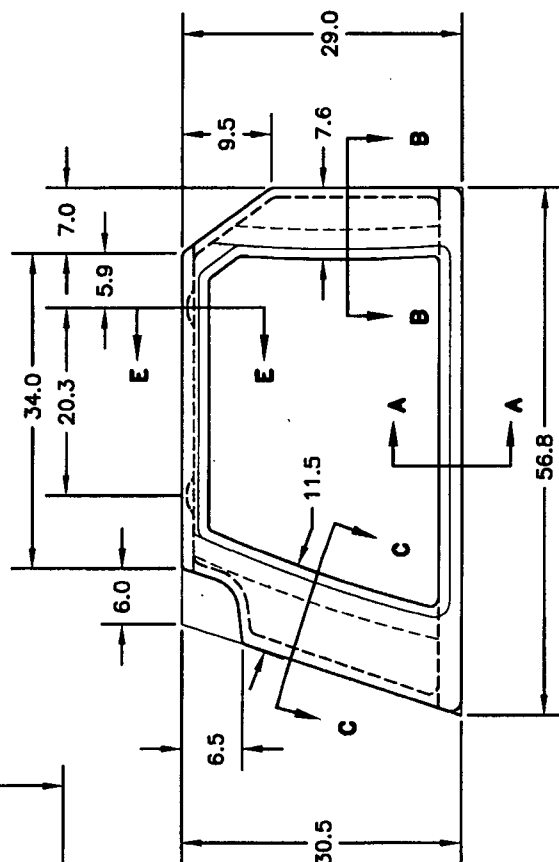
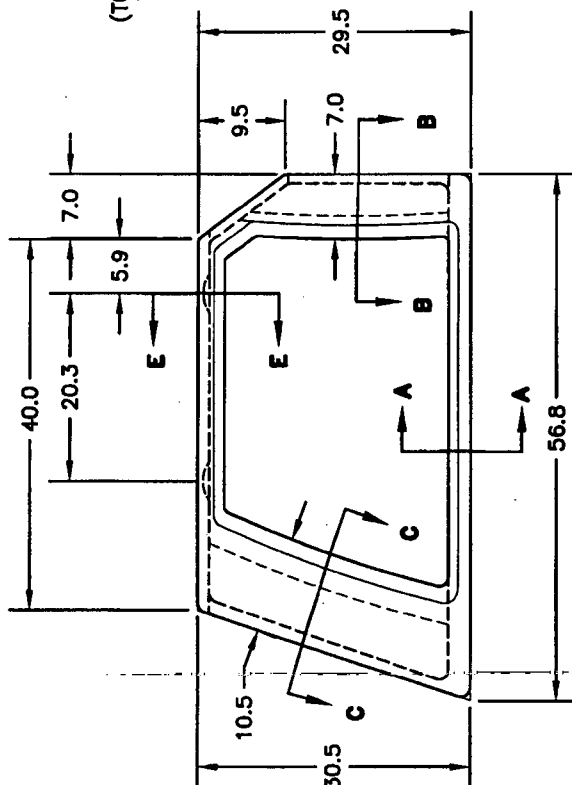
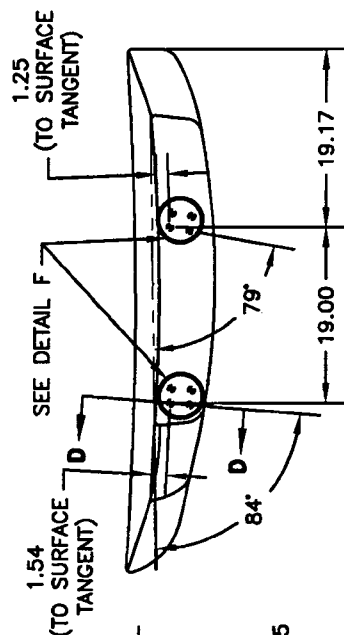
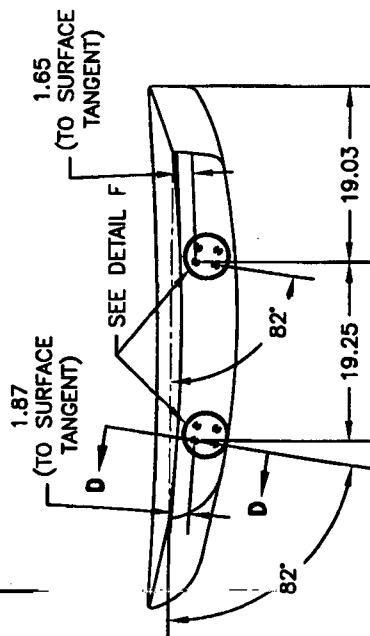
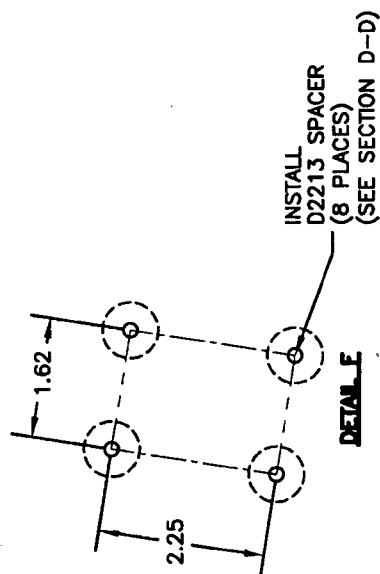
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-3M SPACEPOD BODY

D3188-1M SPACEPOD BODY

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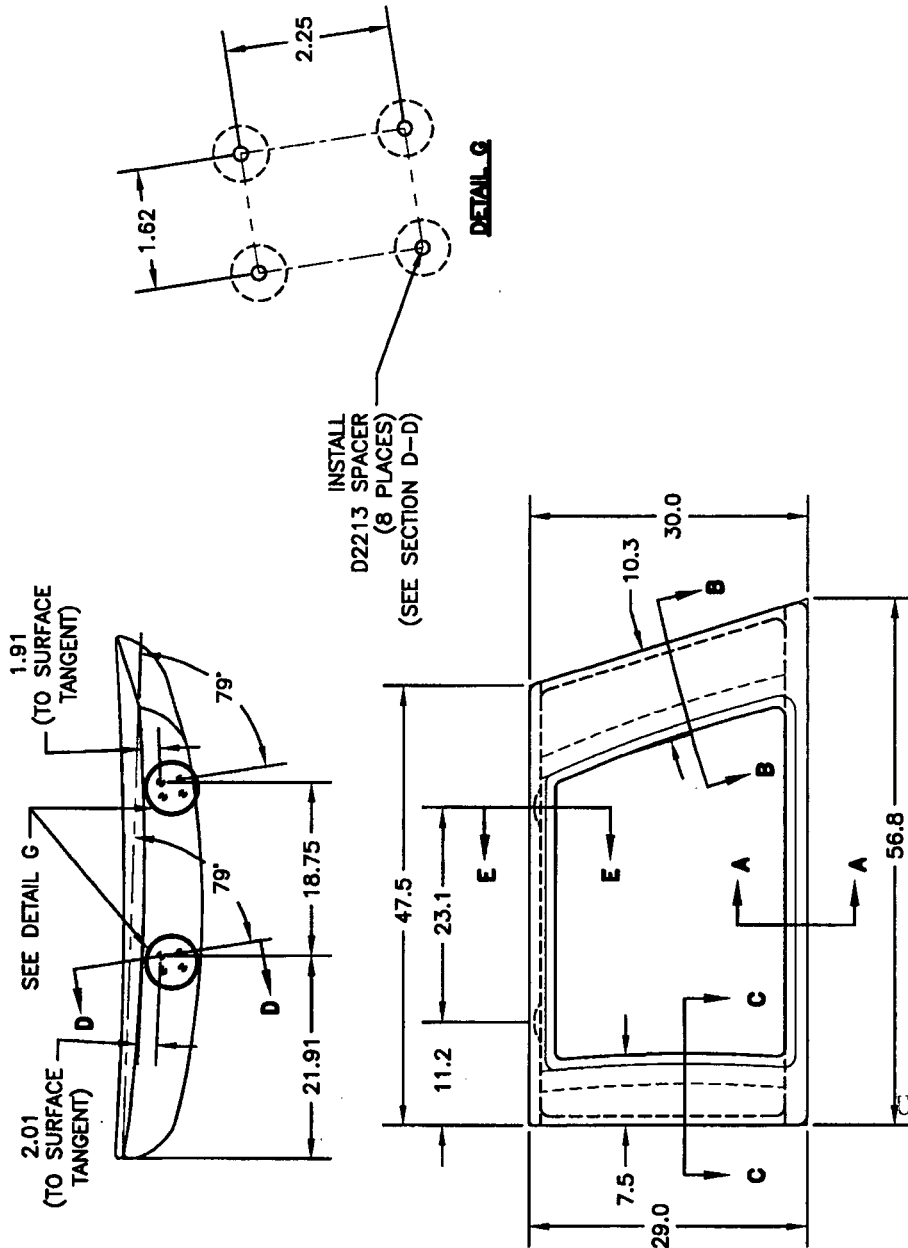
SEE SHEET #4 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS



D3188-2M SPACEPOD BODY

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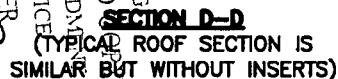
NOTE:
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CHECKED	APPROVED	DRAWING NO.		REV. C
PH	HL	D3188		SHEET 4 OF 11
DATE	TITLE		SCALE	
06.12.13	SPACEPOD BODY		NTS	



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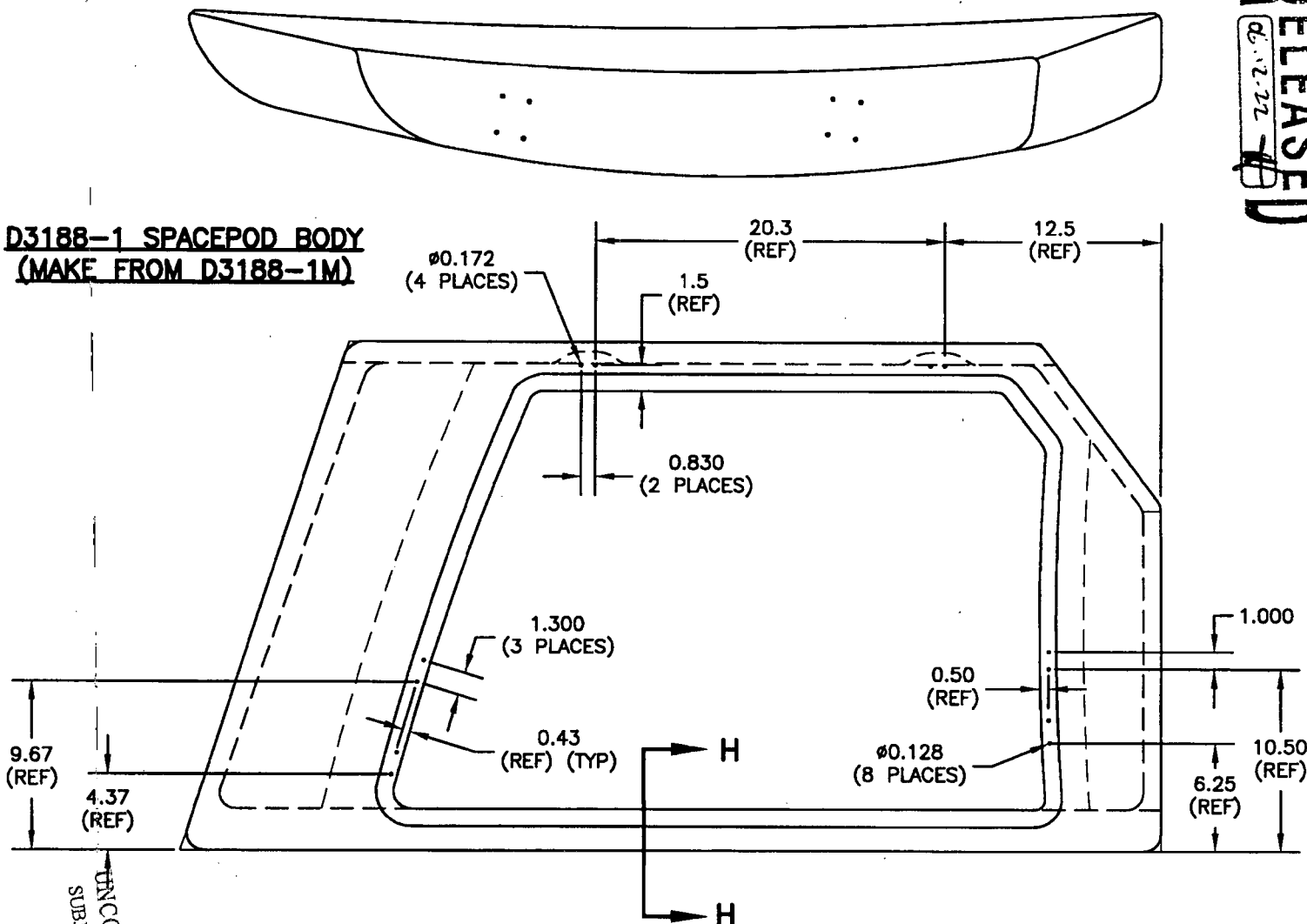
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WORK ORDER
NO. 30010

DART

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DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 5 OF 11
				SCALE
				NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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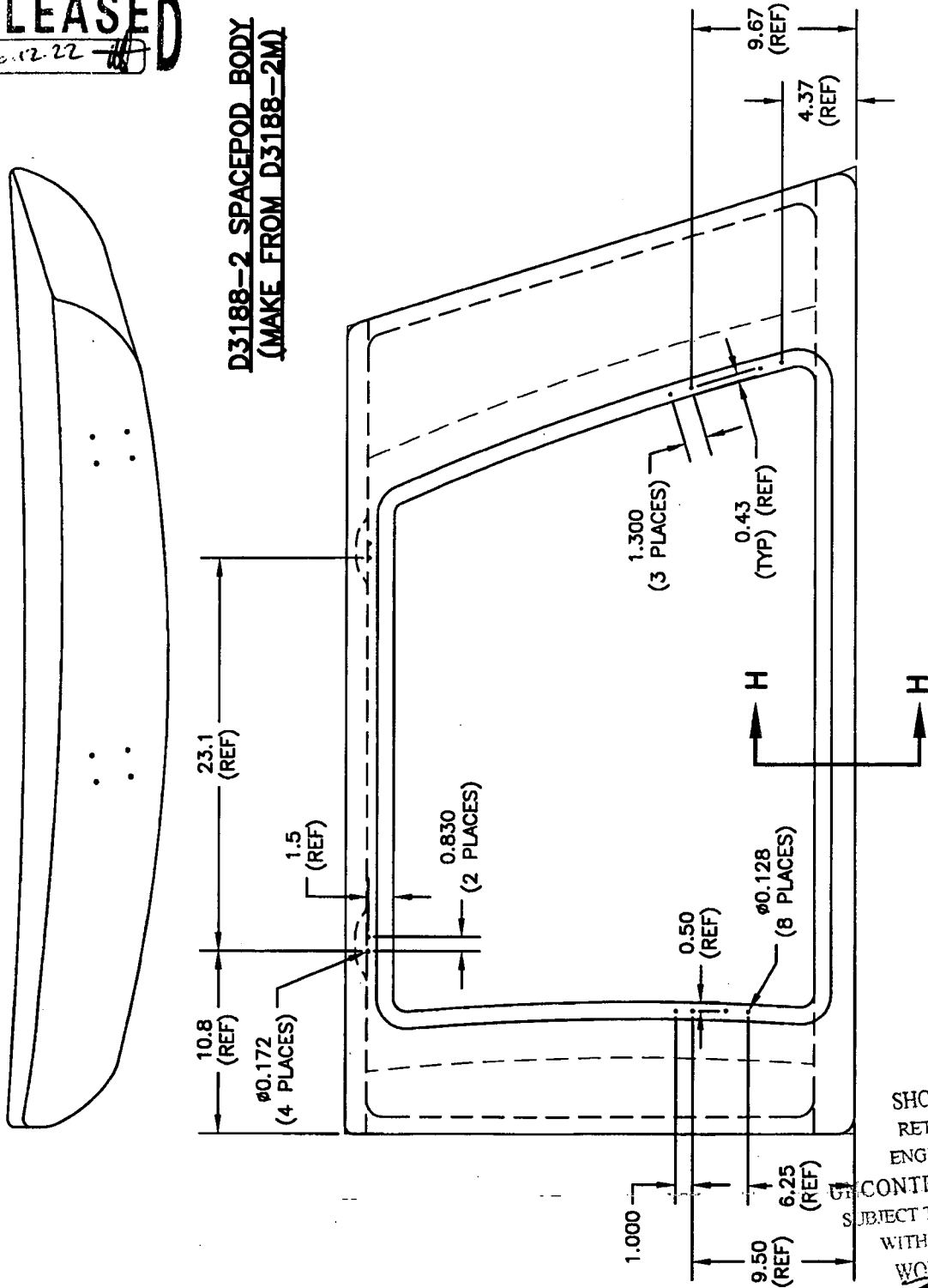
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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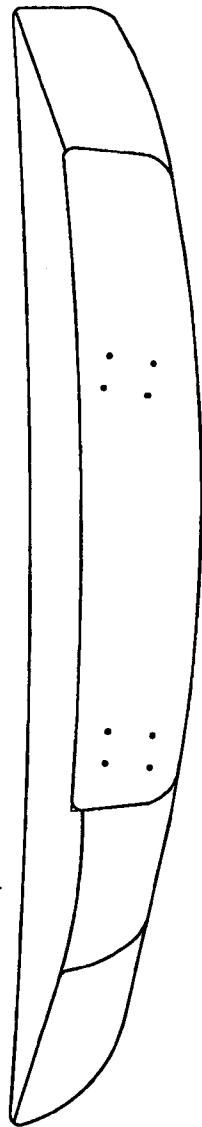
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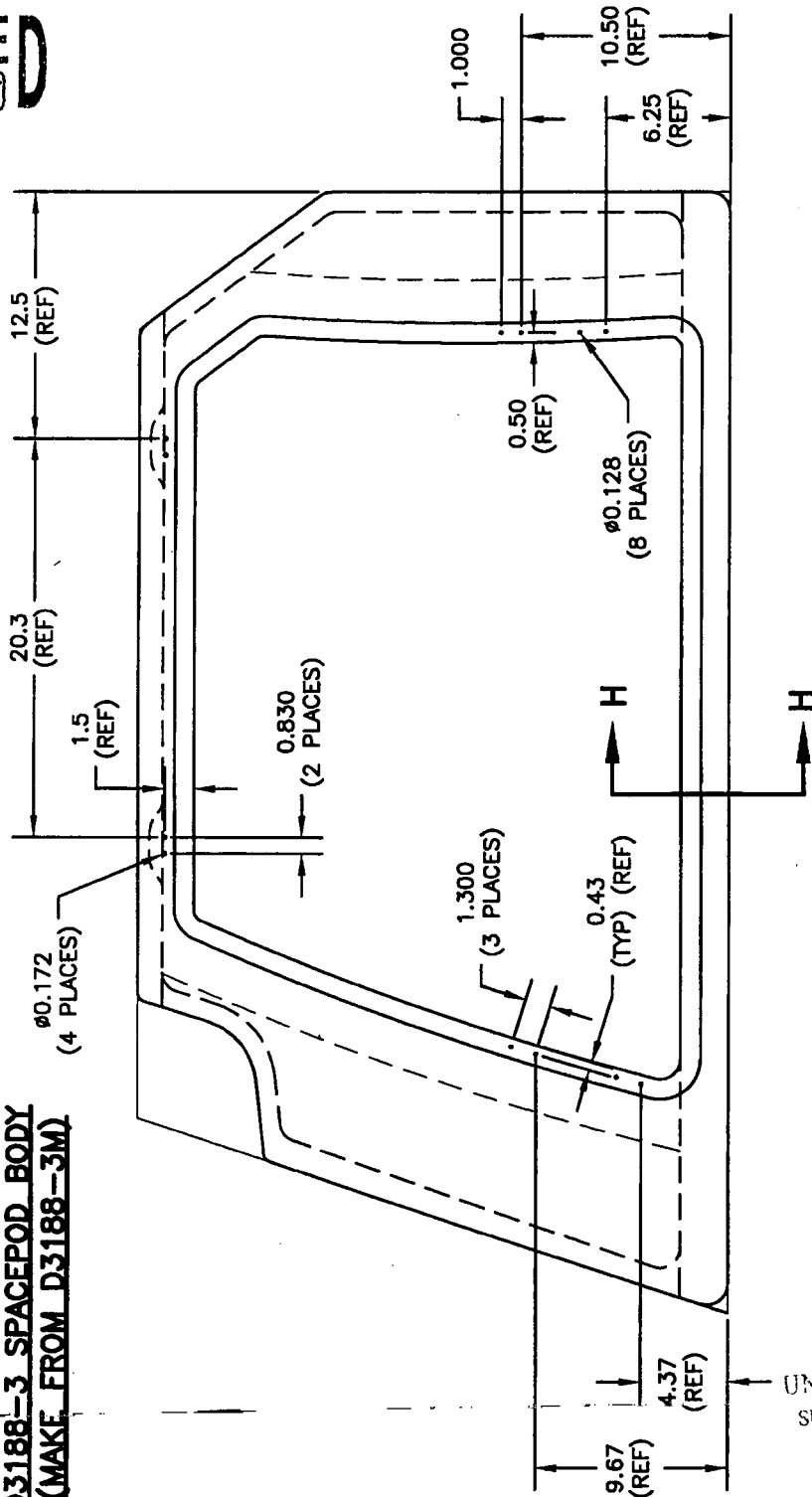


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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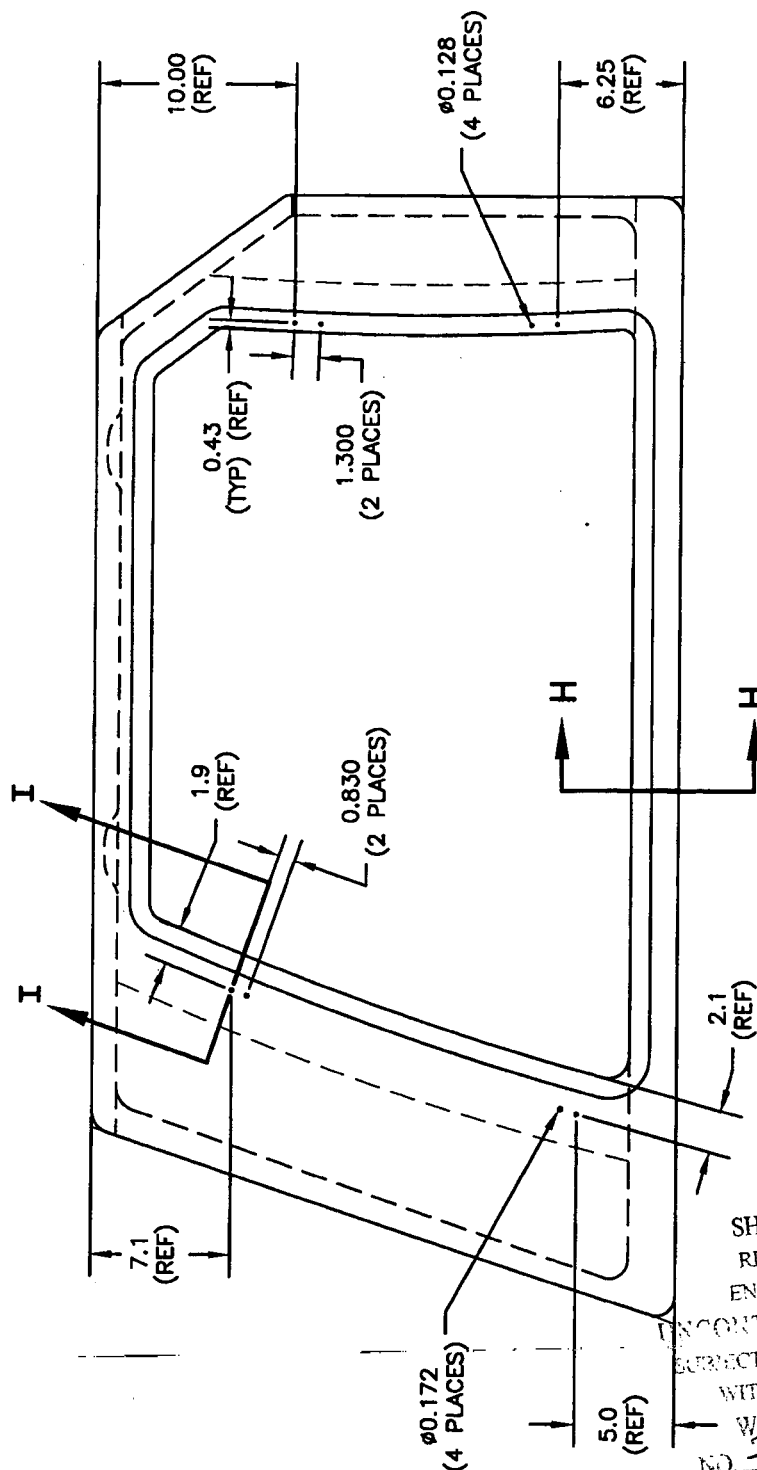
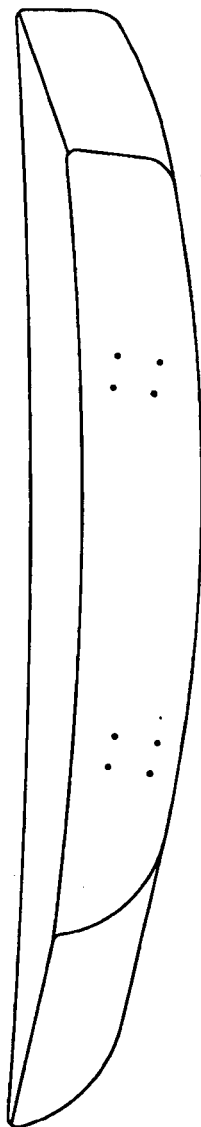
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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

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D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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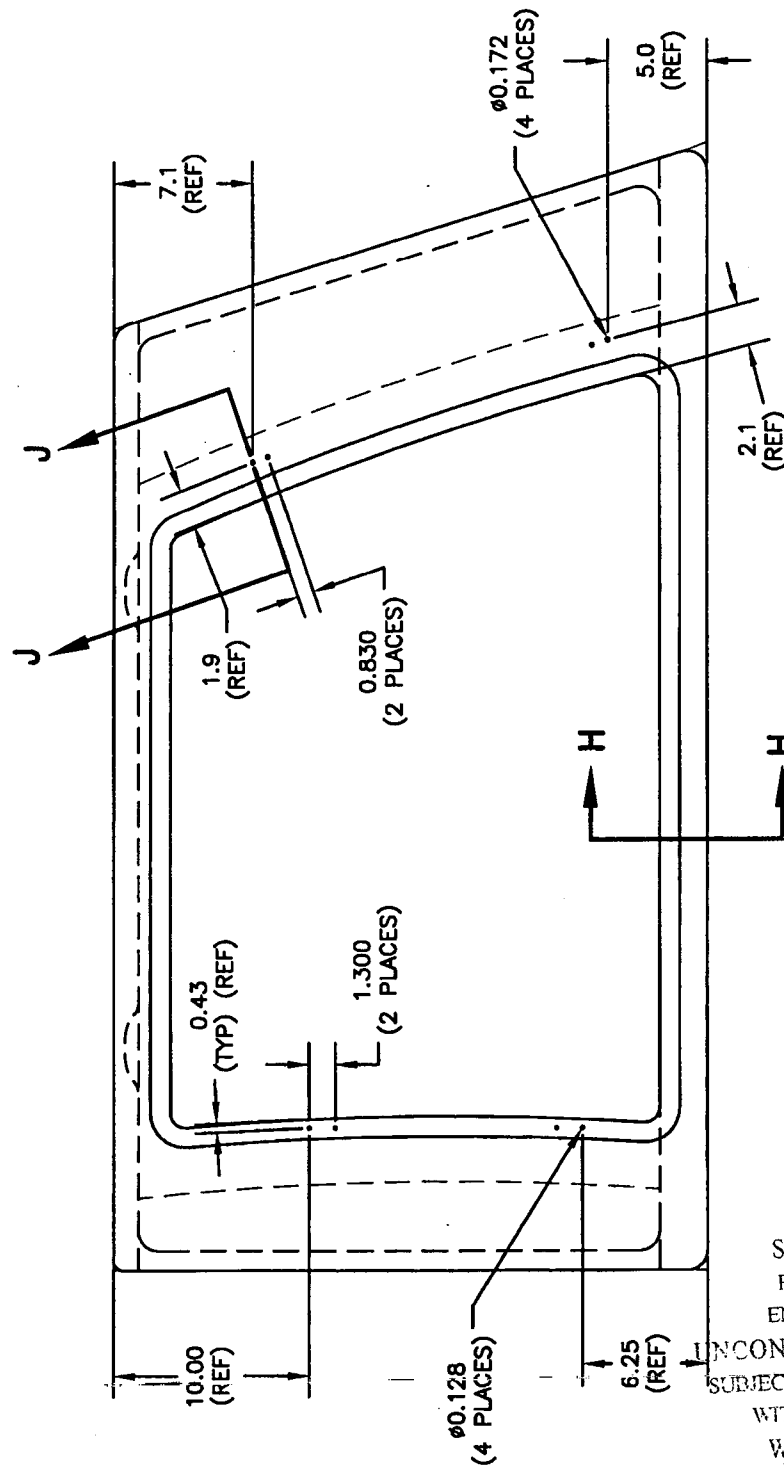
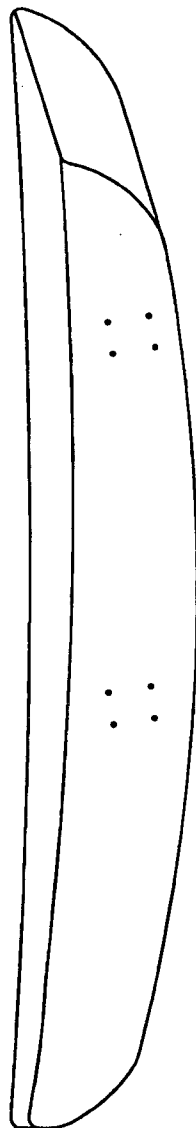
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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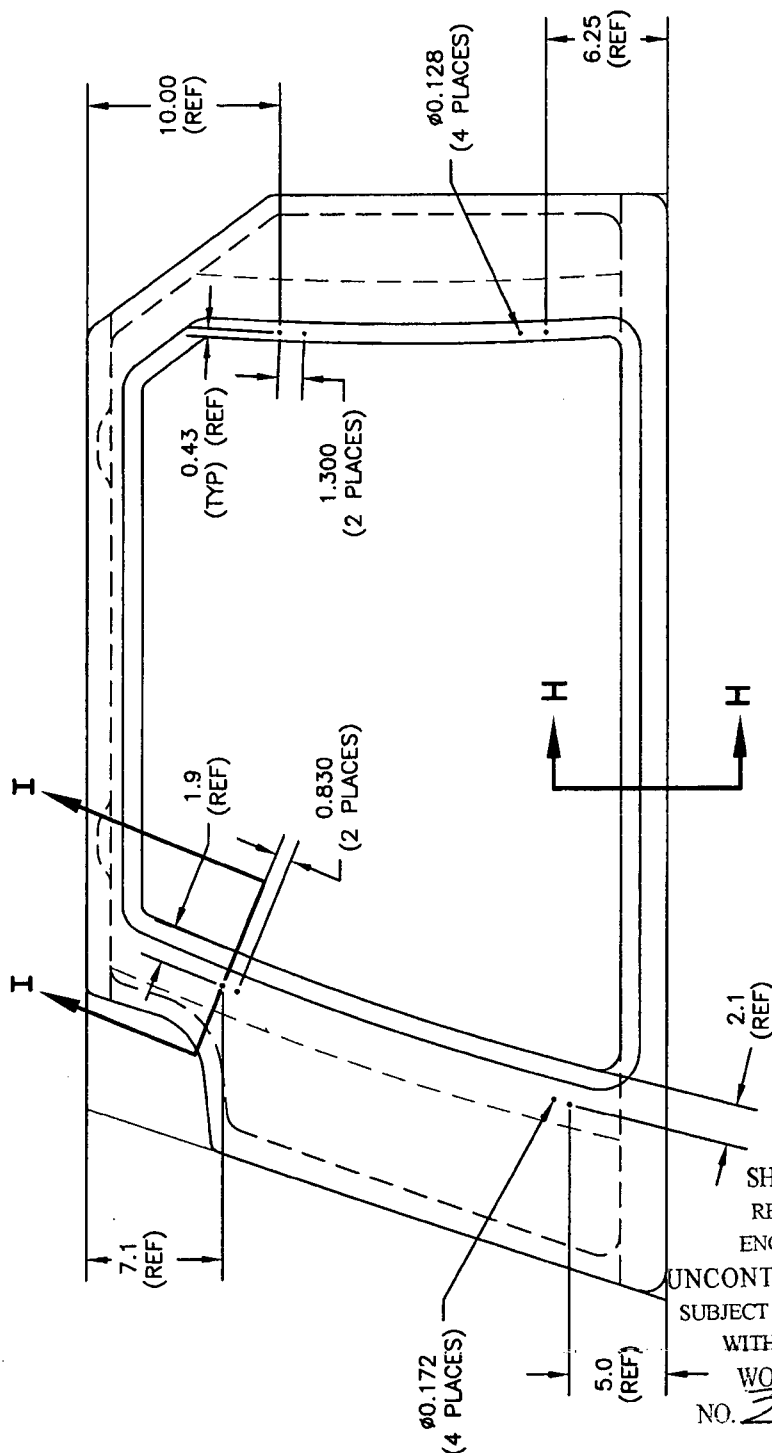
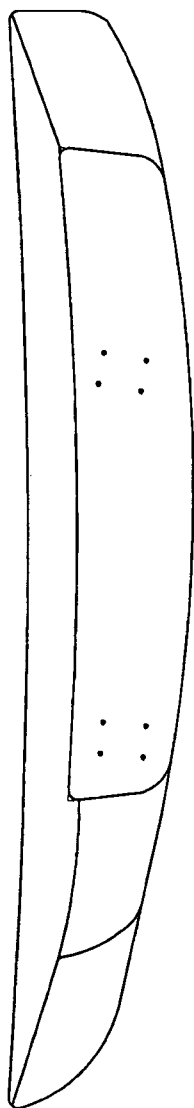
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

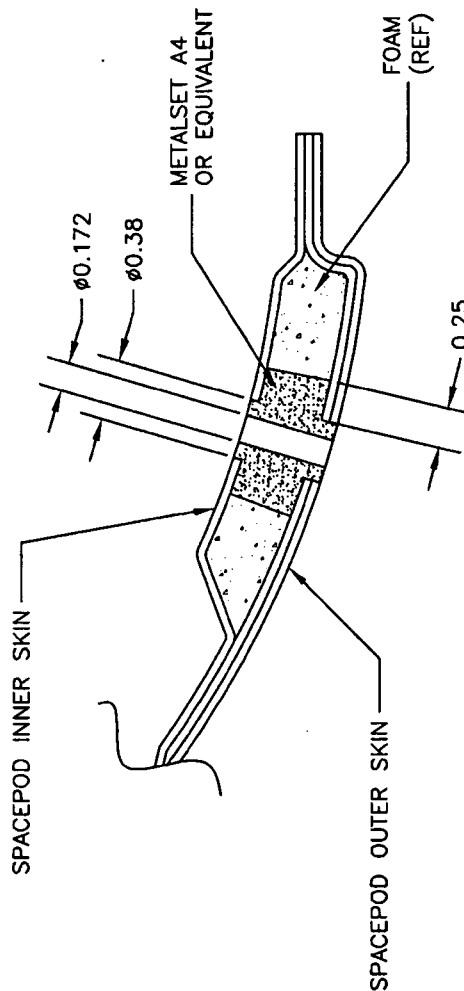
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INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788
Warehouse: MAIN

Invoice #	12007
Customer #	DART

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
14/06/2007	21/12/2006	5092	C. Lavoie	PO00002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30039 Dwg. Rév.: D Job: 41311			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30009 Dwg. Rév.: C Job: 41320 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30019 Dwg. Rév.: D Job: 41302 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30029 Dwg. Rév.: D Job: 41330 U de M : Each			

[Signature] 7/06/18

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

[Signature]
Quality department
AQ-357



Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD BODY	
Numéro Job	: 41302		Numéro Article	: DKC134-0053	
Numéro Soumission	: 2585		Numéro Dessin	: D3188	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2007-03-29	No. B.V. :	Révision dessin	: C	
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350	
Prem. fois	: - -	Type :	Date Dûe	: 2007-04-05	Qté: 1 Udm: UNITE
Job précédente	: 41301				

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Dart Aerospace : D31881M



Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 18/05/07 Heure Début: 2:00 Heure Fin: 4:30 Sceau: _____



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N.10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT 1-6083-1

8.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot:

1-5964-1

10.0

AAC0633

WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot:

1-6113-3

11.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 7/05/07 Heure Début: 8:00 Heure Fin: 12:00 Sceau:



12.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-5921-3

13.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6148-1

14.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-5502-1

15.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxy 66.

MAY 23 2007

Date: 8:45 Heure Début: 8:55 Heure Fin: Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

MAY 23 2007

Date: 8:55 Heure Début: 9:30 Heure Fin: Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

MAY 23 2007

Date: 9:30 Heure Début: 9:50 Heure fin: Sceau:



Curing Début: 8:45 Curing Fin: 1:15

18.0

AAC0457












ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3:5915-2

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Numéro Job: 41302		Nom Dessin: SPACEPOD BODY Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3 	FABRICATION GÉNÉRALE DART 	
Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL Tailler et le Foam Core 1" selon plan de découpe et gabarits Date: <u>MAY 23 2007</u> Heure Début: <u>10:15</u> Heure Fin: <u>12:00</u> Sceau: 			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6148-1</u>			
21.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-5921-3</u>			
22.0	FINITION 3 	FINITION PIÈCE DART 	
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART MAY 23 2007  Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.			
23.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: <u>1-6066-1</u>			
24.0	FINITION 3 	FINITION PIÈCE DART 	
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide de polybond, coller ensemble les deux surfaces scellées. Disposer des poids sur les pièces pour conserver une pression de collage. Laisser sécher 2 heures minimum. Quantité: <u>1</u> Date: <u>MAY 24 2007</u> Sceau:  			

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: /

Date: MAY 24 2007

Sceau:



Quantité:

Date:

Sceau:

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6148-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

1-5921-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DART

MAY 24 2007



Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum

Date: MAY 24 2007

Sceau:















Initiales:

S.V-C.G.

ate: Jeudi, 2007-03-29 10:32:39
utilisateur: Marc Dubé












Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41302		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
30.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-6060-1</u>			
31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation du Polybond. Date: <u>MAY 25 2007</u> Heure Début: <u>1:05</u> Heure Fin: <u>1:15</u> Sceau: 			
32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond. Date: <u>MAY 25 2007</u> Heure Début: <u>1:15</u> Heure Fin: <u>1:50</u> Sceau:  			
33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Feutre de drainage 3- Sac à vide Stretchlon 200 Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé Date: <u>MAY 25 2007</u> Heure Début: <u>1:50</u> Heure Fin: <u>2:00</u> Sceau:   Curing Début: <u>1:15</u> Curing Fin: <u>2:30</u>			
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens N° de Lot: <u>1-6079-1</u>			

Date: Jeudi, 2007-03-29 10:32:39

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41302		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
35.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
36.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FINITION GÉNÉRALE Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond. Date: <u>MAY 28 2007</u> Heure Début: <u>10:15</u> Heure Fin: <u>12:00</u> Sceau:  			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule. Date: <u>MAY 28 2007</u> Sceau: 			
38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6148-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-5921-3</u>			
40.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core Laisser sécher pendant 2 heures minimum. Quantité: <u>/</u> Date: <u>MAY 29 2007</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____			

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total: 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

1-5921-3

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6148-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: MAY 29 2007

Heure Début:

12:40

Heure Fin:

12:45

Sceau:



44.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: MAY 29 2007

Heure Début:

12:45

Heure Fin:

1:30

Sceau:



45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE











Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200








Laisser sécher pendant 4 heures minimum.

ate: Jeudi, 2007-03-29 10:32:39
utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41302		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: MAY 2 0 2007	Heure Début: 1:30	Heure Fin: 1:45
	Curing Début: 12:45	Curing Fin: 8:00	Sceau:   
46.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs DÉMOULAGE DES PIÈCES Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce. Date: MAY 3 0 2007			
	Heure Début: 8:45	Heure Fin: 10:00	Sceau: 
47.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs TRIMAGE DE FINITION Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801. Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. (Ne pas percer la peau extérieur de la pièce) Date: MAY 3 0 2007			
	Heure Début: 10:30	Heure Fin: 11:30	Sceau: 
48.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-5921-3			
49.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6148-1			
50.0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: 1-5502-1			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41302		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
51.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>JUN 01 2007</u> Heure Début: <u>8:00</u> Heure Fin: <u>8:05</u> Sceau: </p>			
52.0	AAC0448	Spacer N° D2213	
<p>Commentaire Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s) Spacer N° D2213 N° de Lot: <u>1-5949-1</u></p>			
53.0	ASSEMBLAGE 3 	ASSEMBLAGE GÉNÉRALE DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs ASSEMBLAGE GÉNÉRALE DES PIÉCES</p> <p>Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66</p> <p>Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers.pour reboucher les trous.</p> <p>Appliquer un pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>JUN 01 2007</u> Heure Début: <u>8:05</u> Heure Fin: <u>9:00</u> Sceau: </p> <p>Curing Début: <u>8:05</u> Curing Fin: <u>12:30</u></p>			
54.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>1-5921-3</u></p>			
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6148-1</u></p>			

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job: 


Séq.: Machine ou Opération: Description :

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: MAY 31 2007 Heure Début: 10:15 Heure Fin: 10:20 Sceau: 

57.0 LAMINAGE LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: MAY 31 2007 Heure Début: 10:20 Heure Fin: 11:15 Sceau:  

Curing Début: 10:20 Curing Fin: 8:00


58.0 FINITION 3 FINITION PIÈCE DART




Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections.

Percer les 8 trous des spacers afin de les déboucher.

Quantité: 1 Date: JUN 04 2007 Sceau: 

Quantité: 1 Date: 05-6-07 Sceau: 

59.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

Date: Jeudi, 2007-03-29 10:32:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41302

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

60.0

AAC0670

Dupont Activation N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activation N° 7975S

61.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyage Qty 1 05-06-07

JUN 05 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: JUN 05 2007

Heure Début:

Heure Fin:

Sceau:



64.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

65.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

66.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 06-07

Heure Début: 8:30

Heure Fin: 2:30

Sceau:



0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6149-1

68.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)

Dupont Reducer N° 12375S N° de Lot: 1-5092-2

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Nettoyage aty 1 07-06-07

JUN 07 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

71.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

JUN 07 2007

Heure Début: _____ Heure Fin: _____ Sceau: _____



72.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 11/06/07 Sceau: _____ Initiales: N.S.



Emballer . AT:1

11/6/07



Date: Thursday, 5/10/2007 2:30:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 32296A		
Estimate Number	: 12595		
P.O. Number	:	Part Number	: D31881M
This Issue	: 5/10/2007 S.O. No. :	Drawing Number	: D3188 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 32295A	Material	:
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.05.10</u>		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC est rev B revc dwg 07.01.11 ec est rev C revD dwg 07.03.07 ec est rev D rev E dwg 07.04.16 EC		

Additional Product

W/o 30019

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: _____
 Description: D3188-1M BODY
 Ship: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:30:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 32296A

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.04.09

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED [Signature]	REV. E
DATE 07.04.02	D3188	SHEET 1 OF 11
	TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

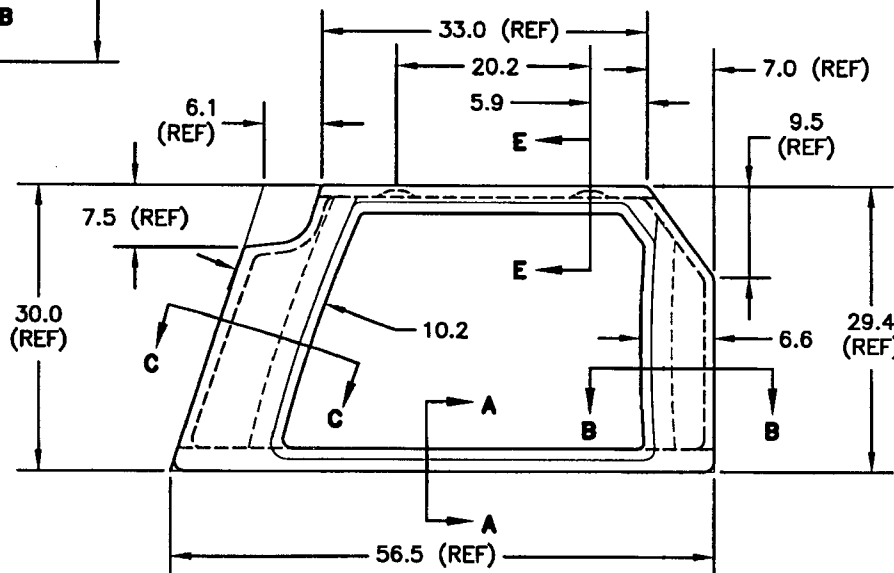
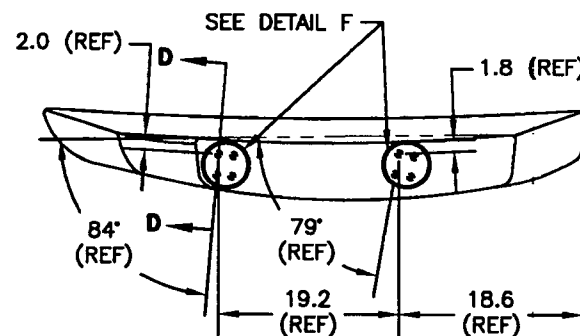
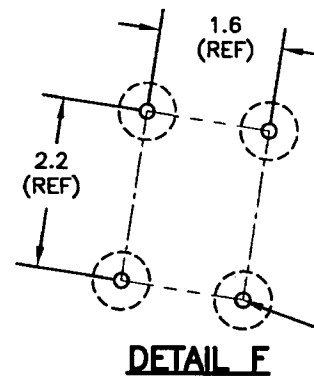
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WITHOUT NOTICE
WORK ORDER
NO. 3229614

DART

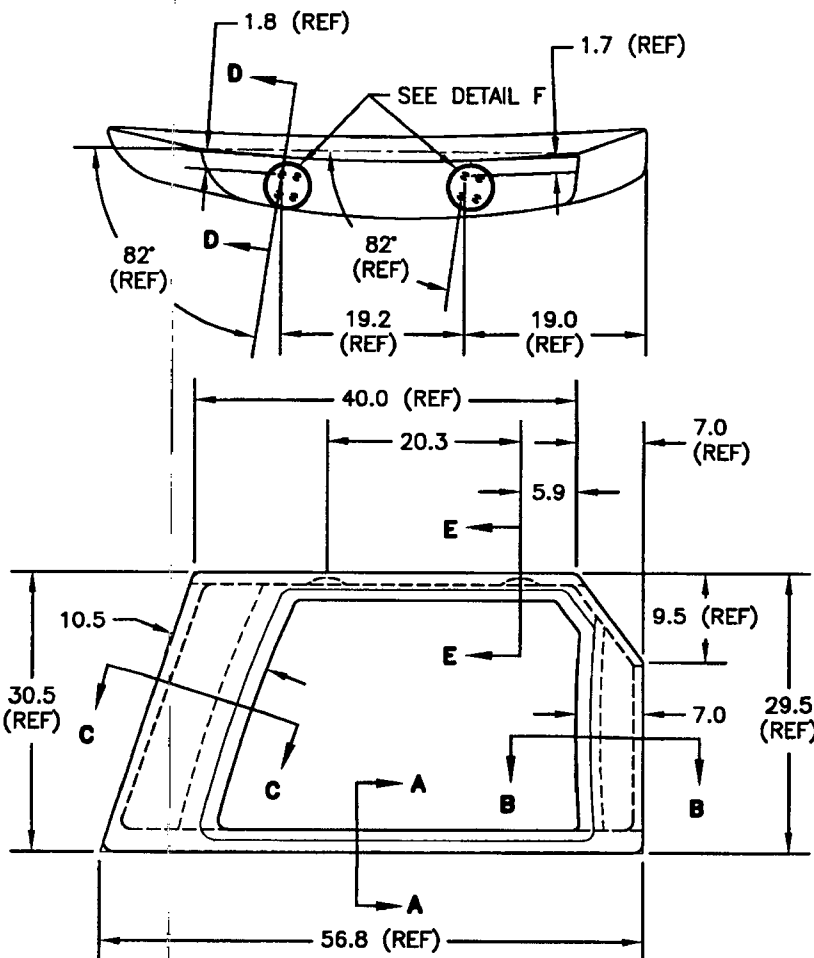
RELEASED

07-04-01

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
JB	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 11
07.04.02		D3188	
DATE	TITLE	SPACEPOD BODY	SCALE
			NTS



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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WORK ORDER
NO 322967A

D3186-1M/-3M NOTES:

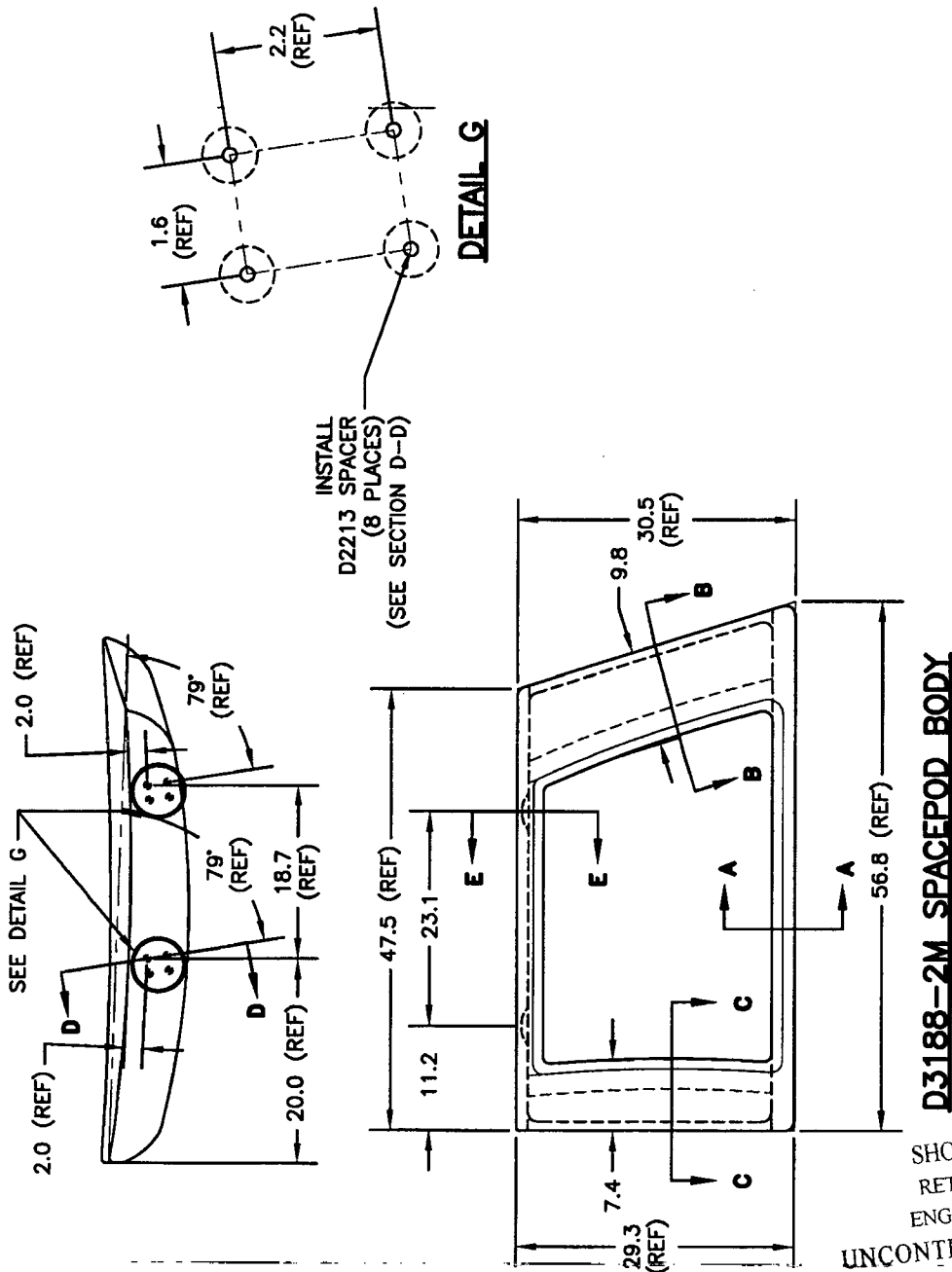
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 3 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 **[Signature]**



D3188-2M SPACEPOD BODY

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WORK ORDER
NO. **32296A**

D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

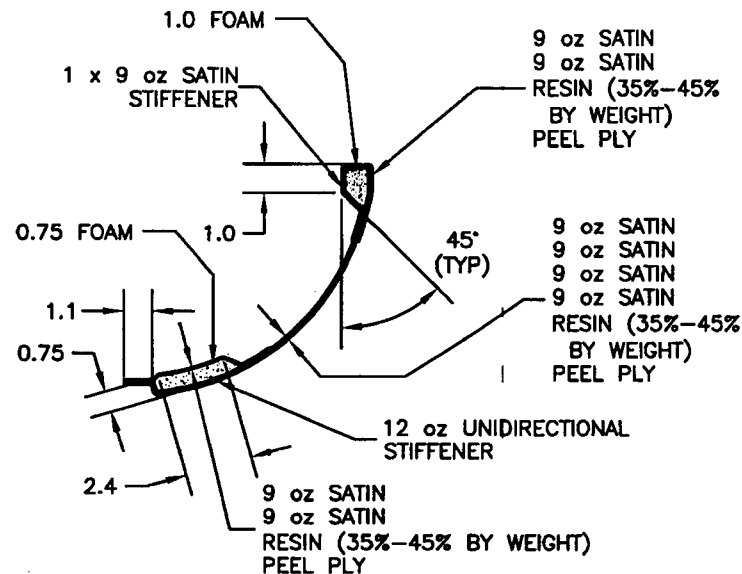
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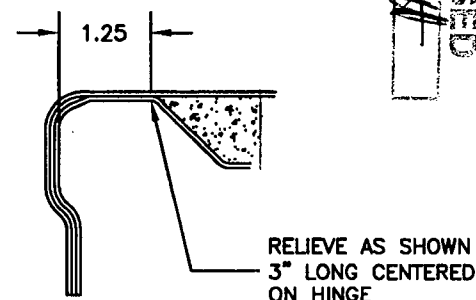
DART

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DATE	07.04.02	TITLE	D3188	REV. E
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

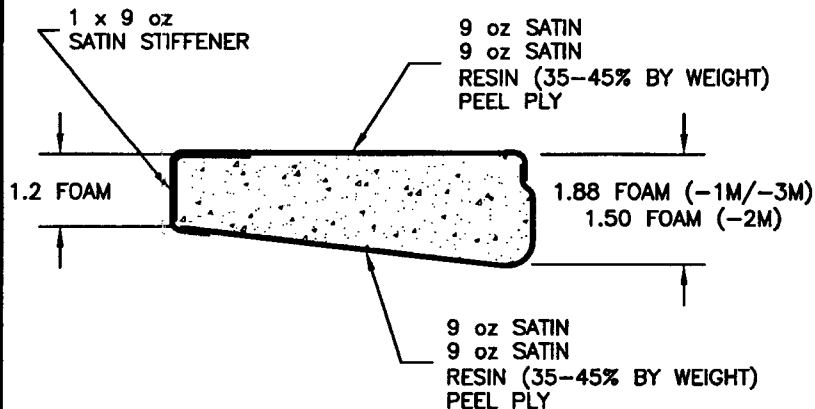
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07.04.01



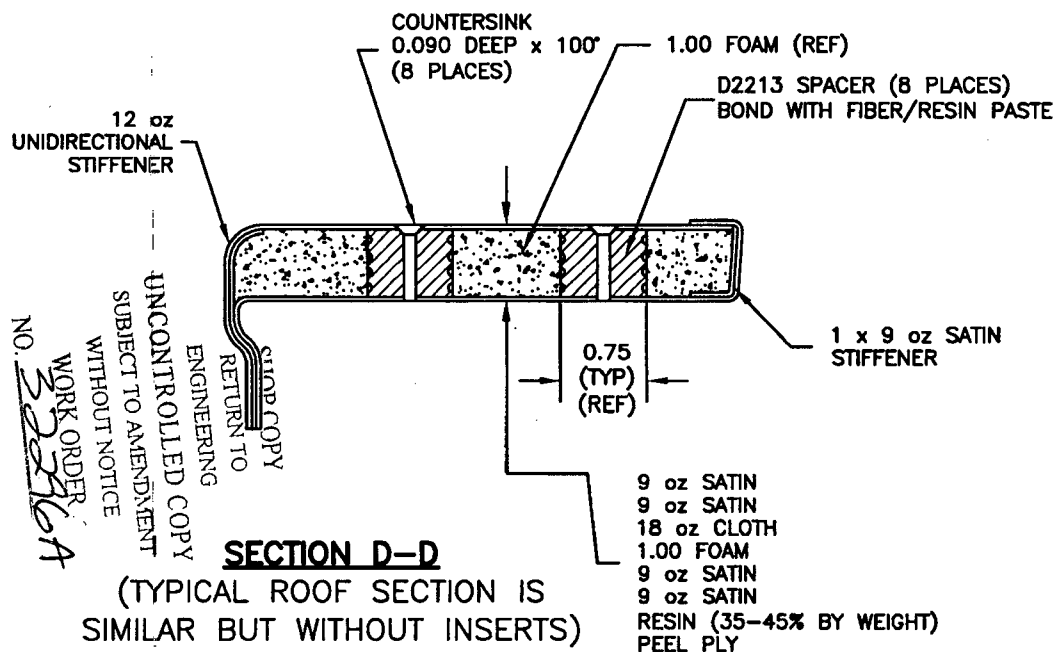
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION E-E
(2 PLACES PER POD)



SECTION A-A
(TYPICAL FLOOR SECTION)



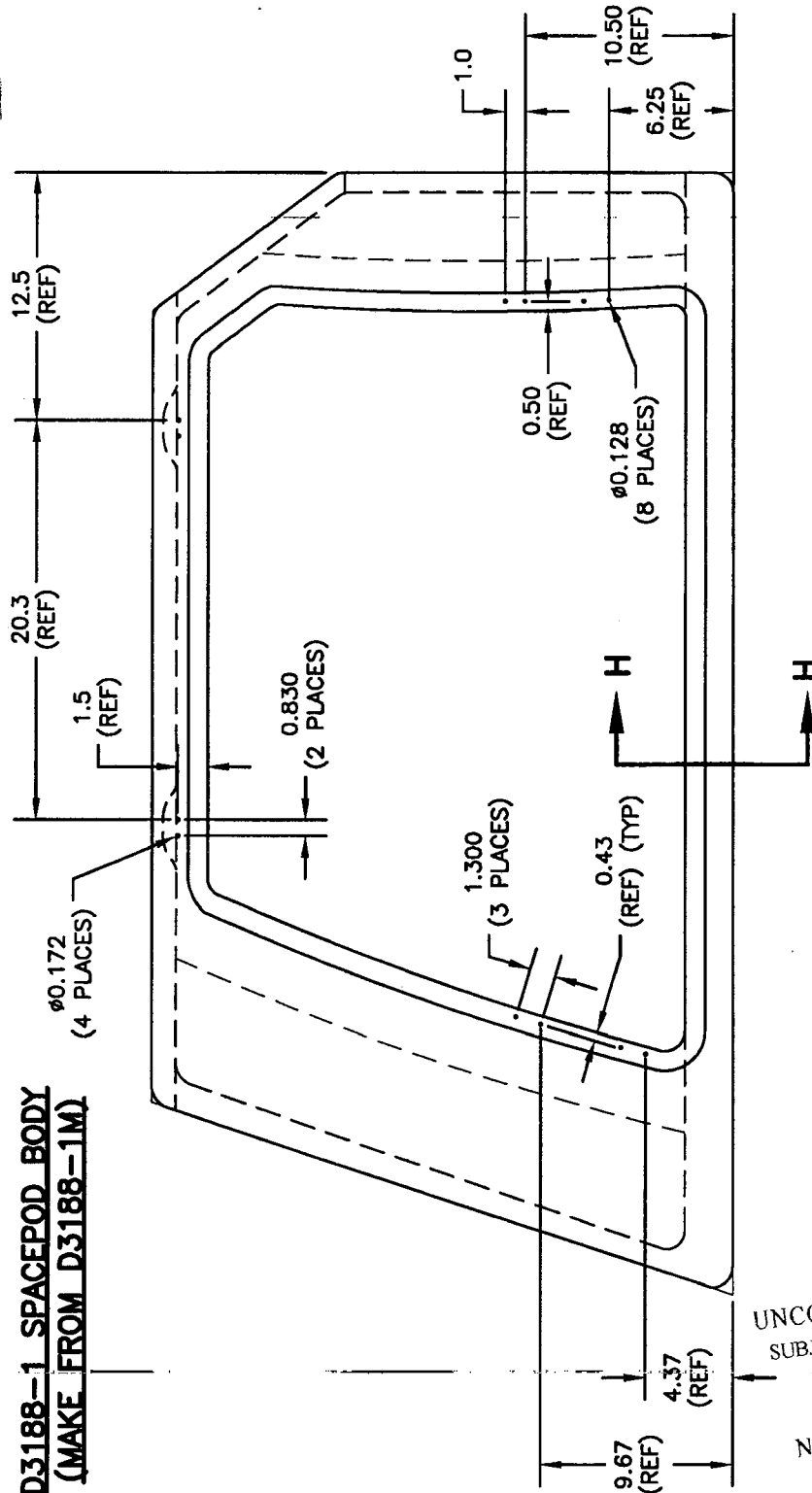
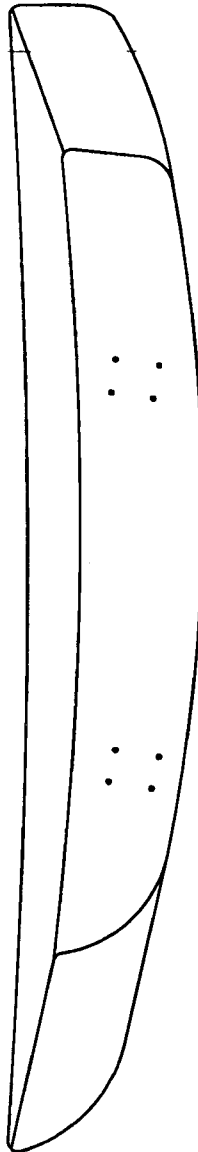
SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

DART

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CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 5 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

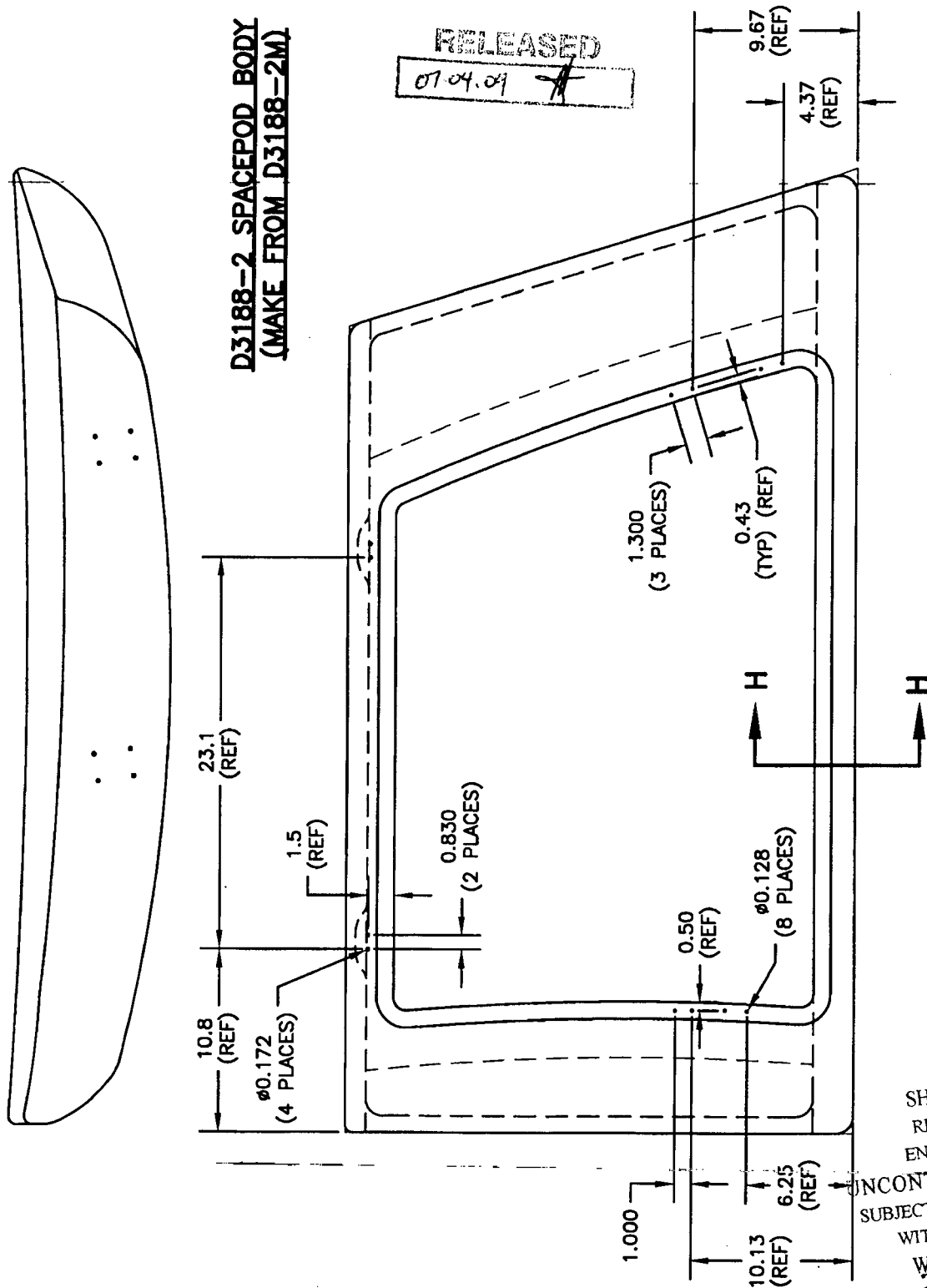
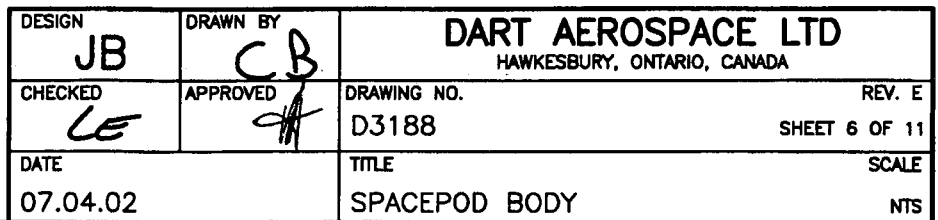
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

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NOTES:

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY

2) SEE SHEET #11 FOR SECTION VIEW

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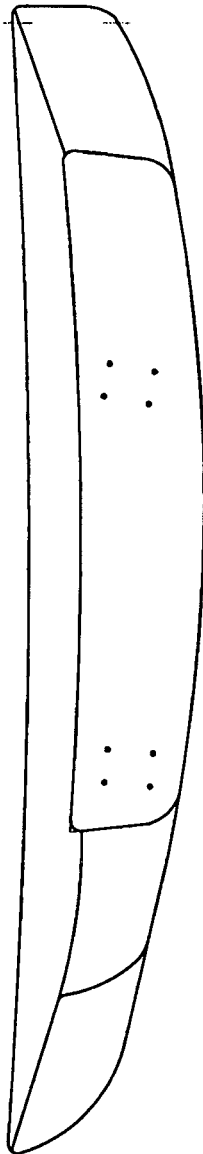
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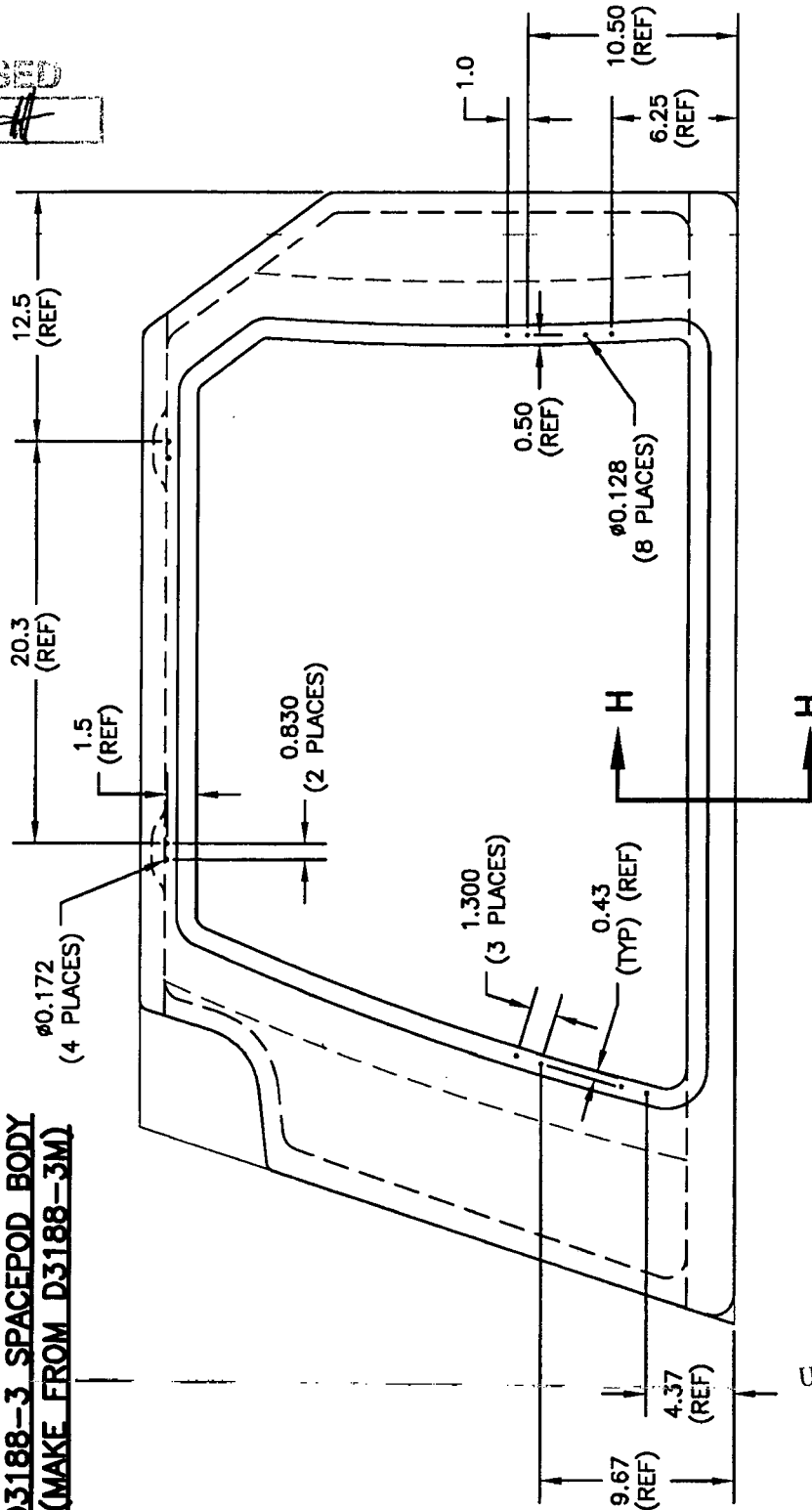
DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 7 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 H



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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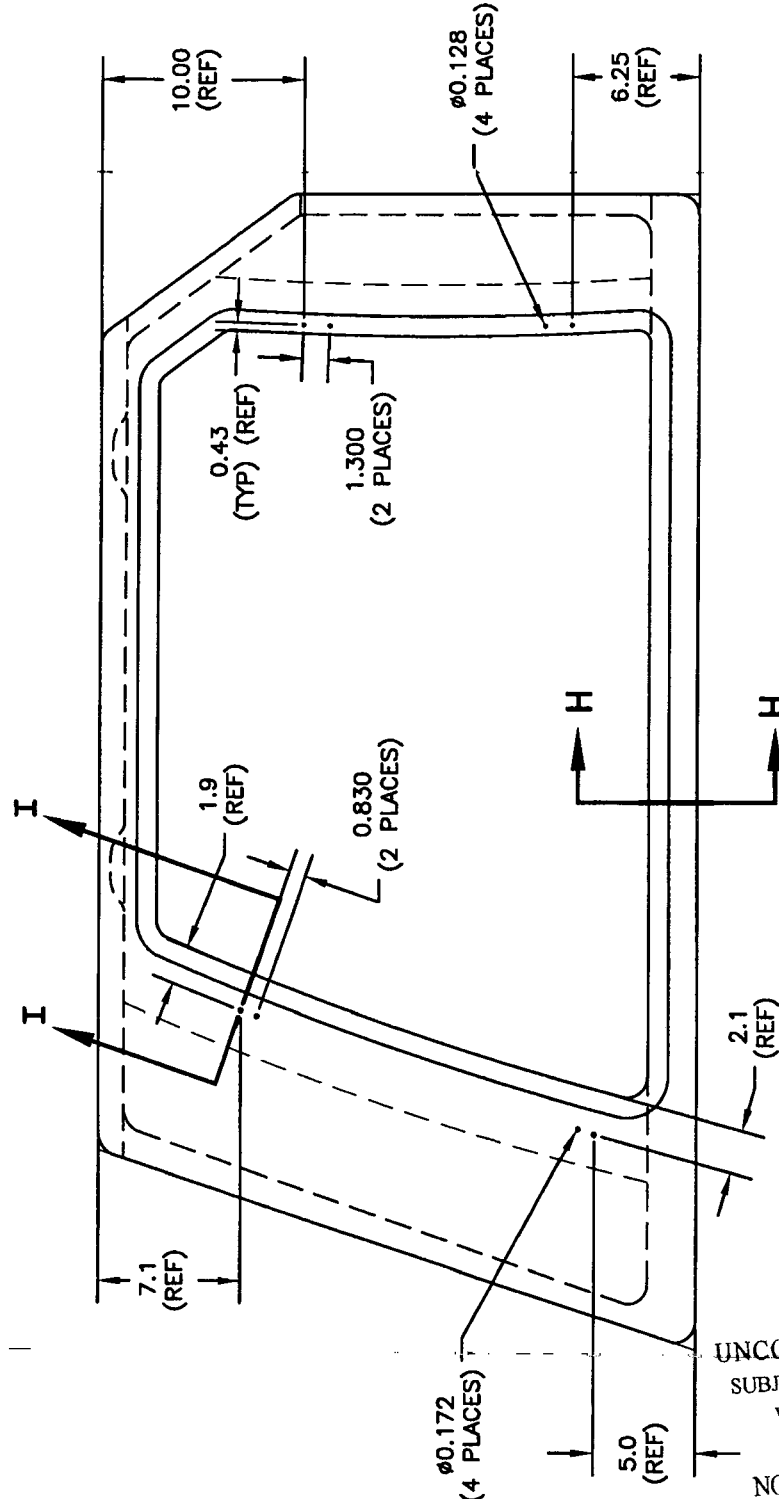
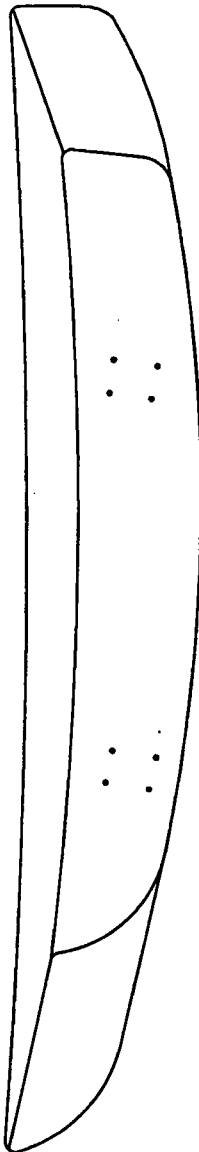
DART

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CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 8 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 H

**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

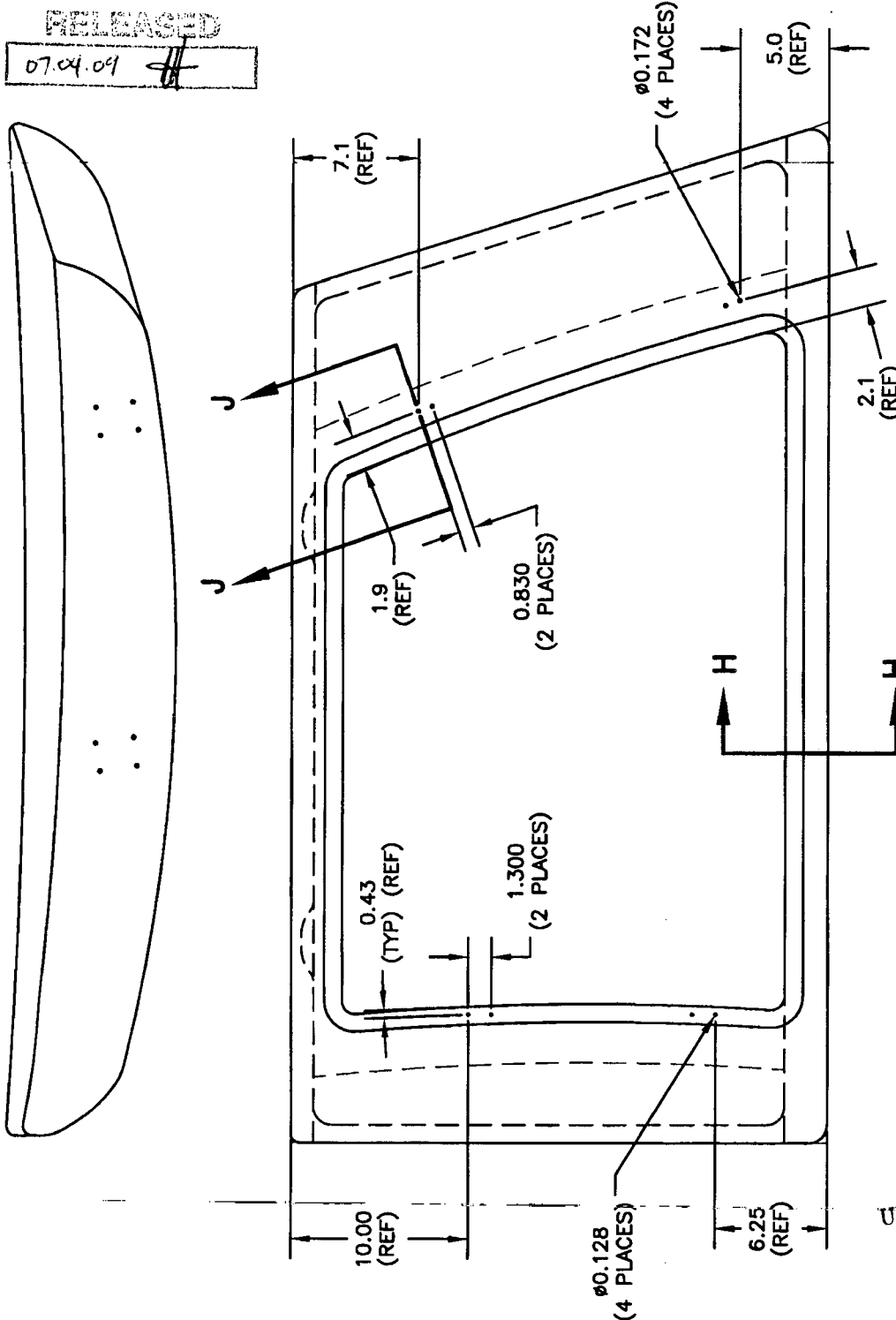
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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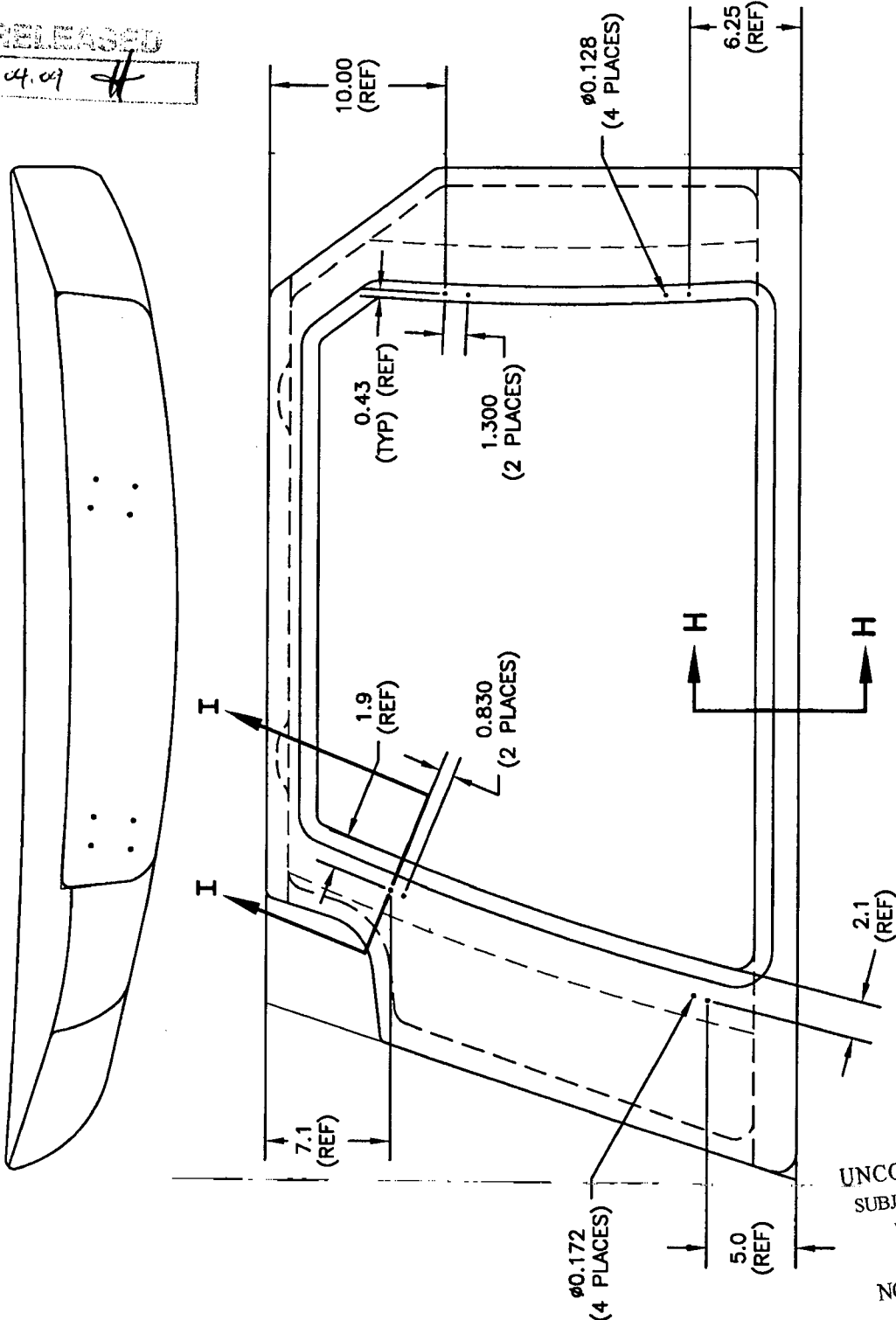
DART

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 10 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 [Signature]

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



- NOTE:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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DART

DESIGN JB	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

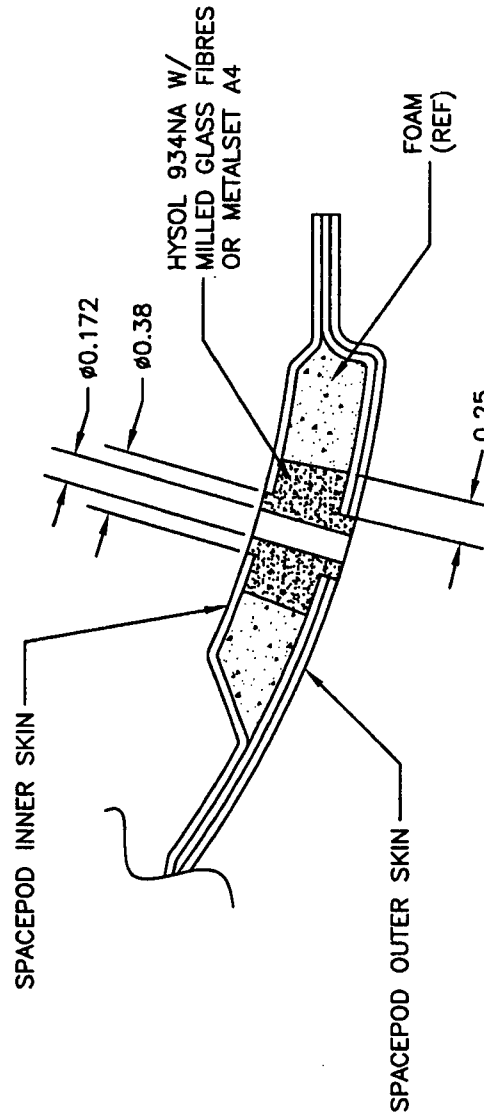
RELEASED

01.04.09

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Thursday, 5/10/2007 2:30:19 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 32296B01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 5/10/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 32295B01	Material	:
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Kim Johnston 07.05.10</u>		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of door is smooth, no dimples for drilling.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O 30009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:30:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 32296B01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

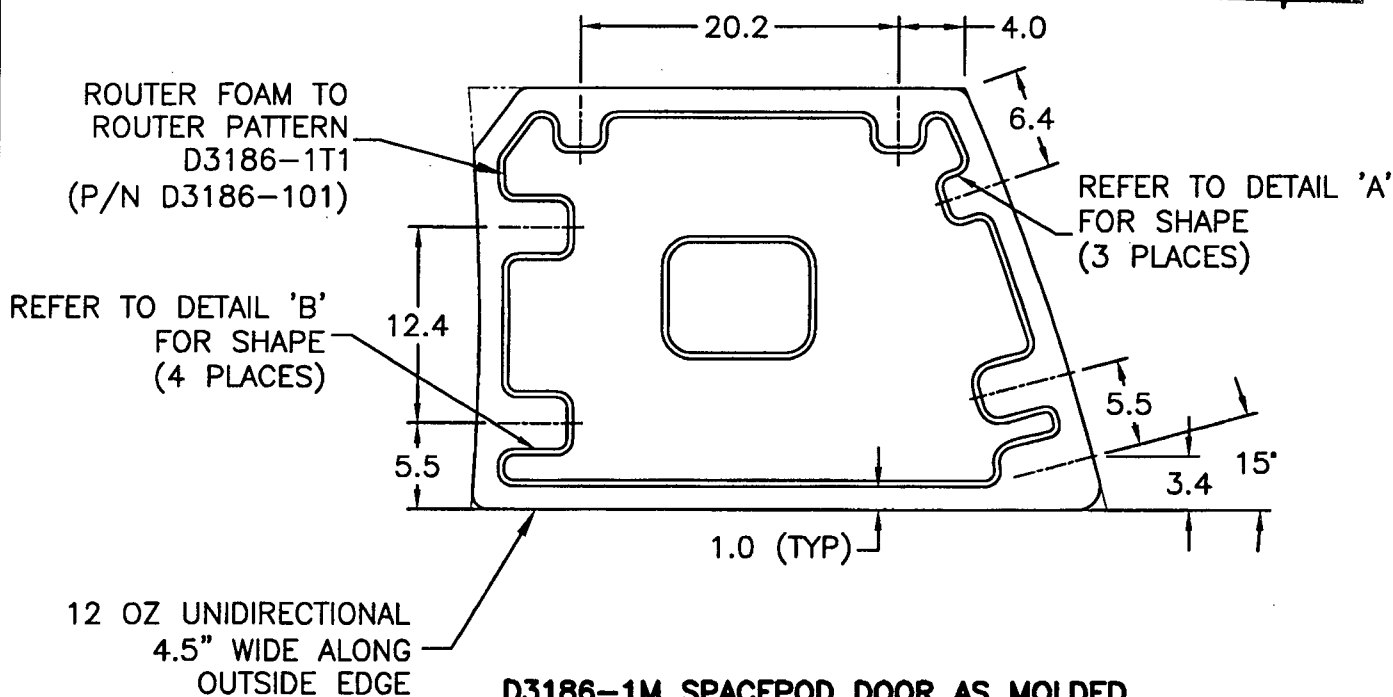
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI-006-4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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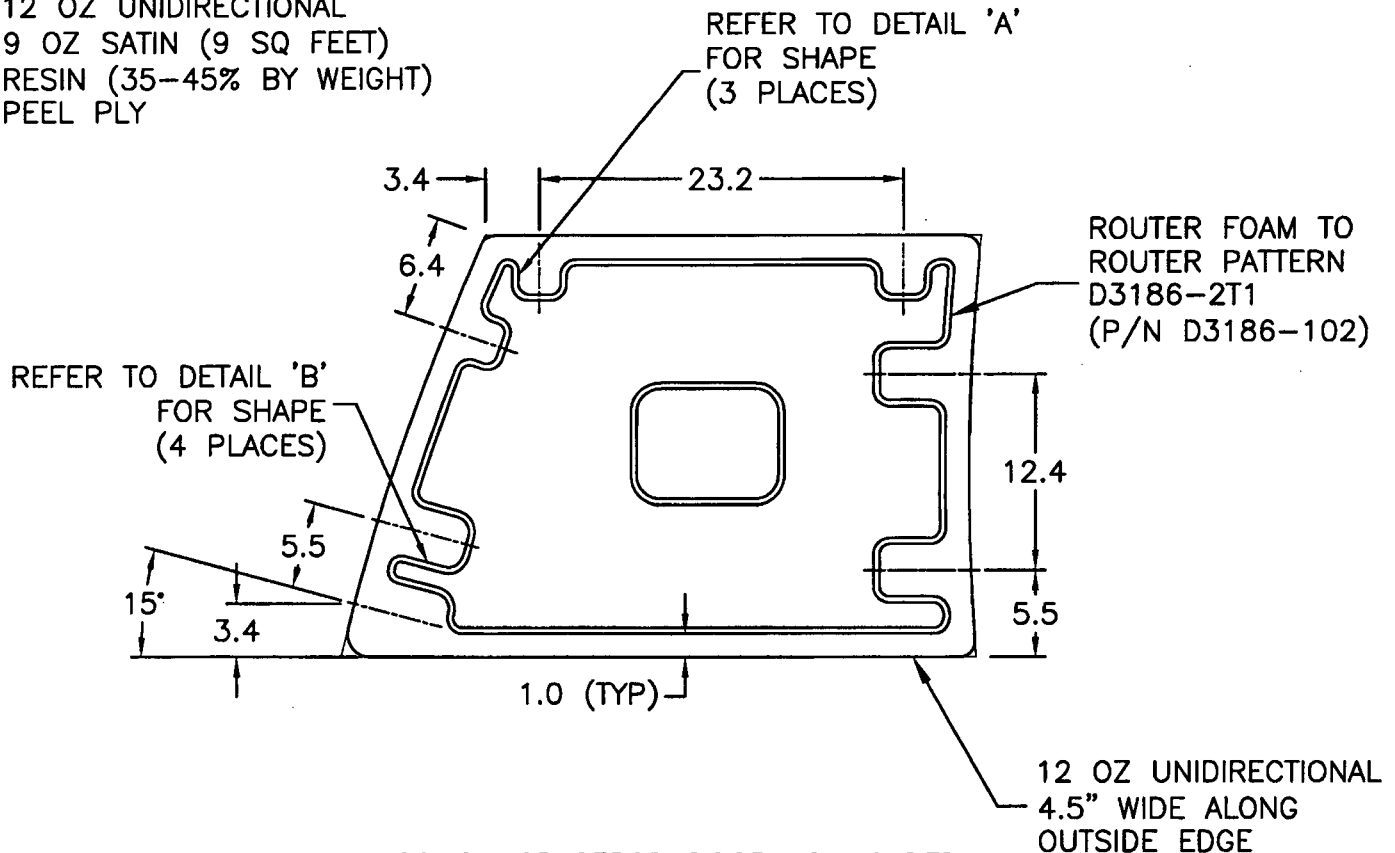
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D31P6-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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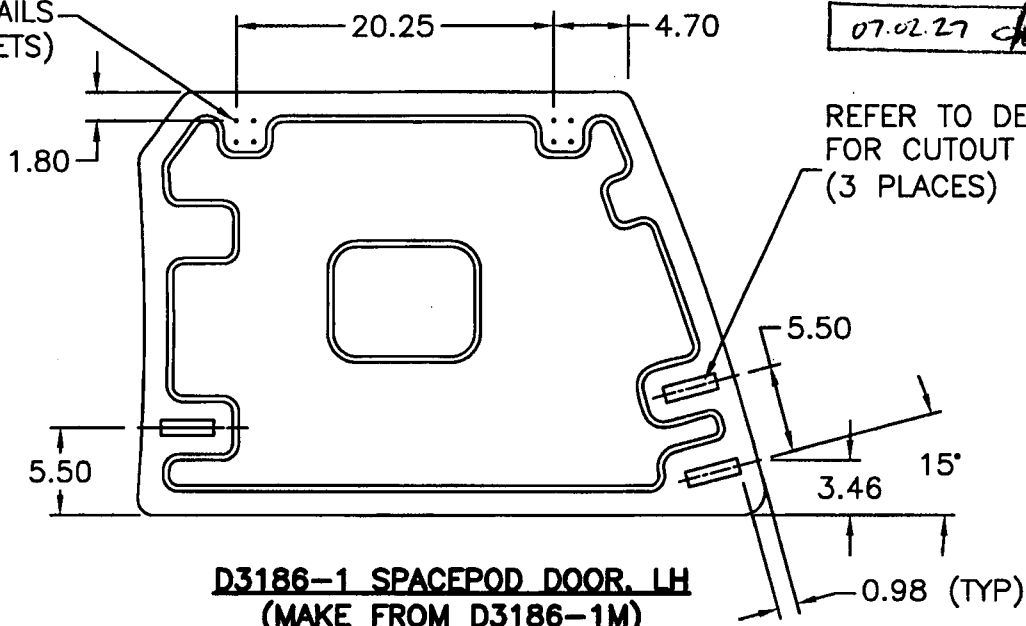
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

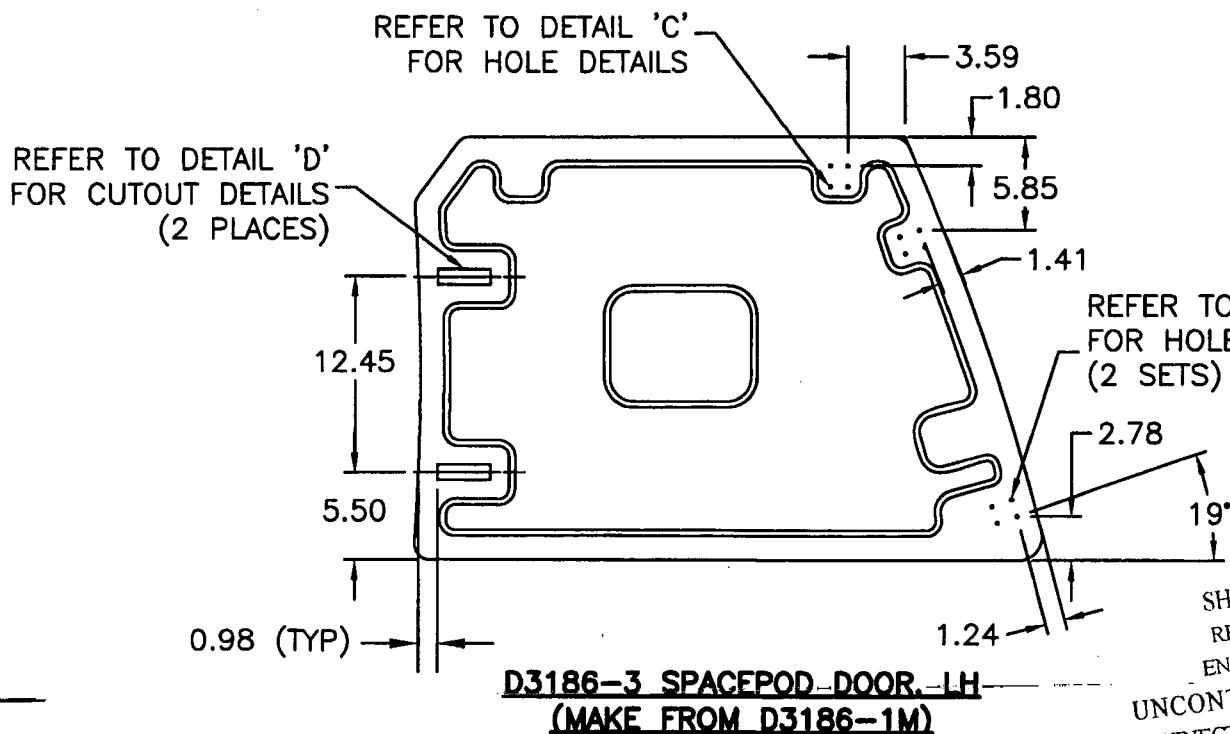
REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



RELEASED

07.02.27

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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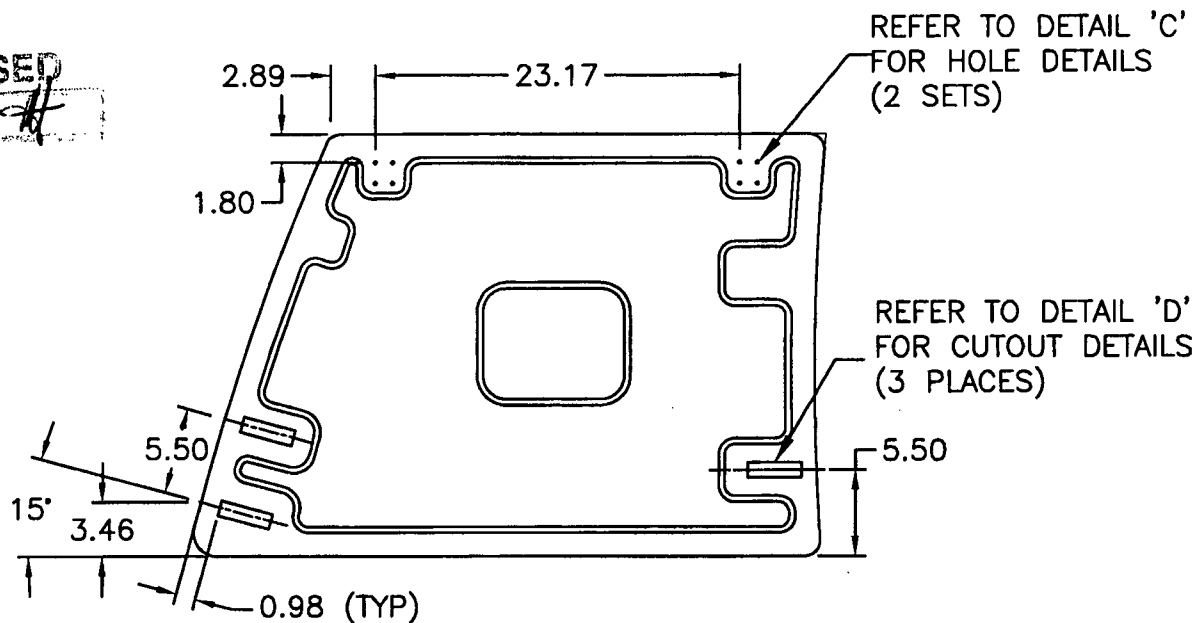
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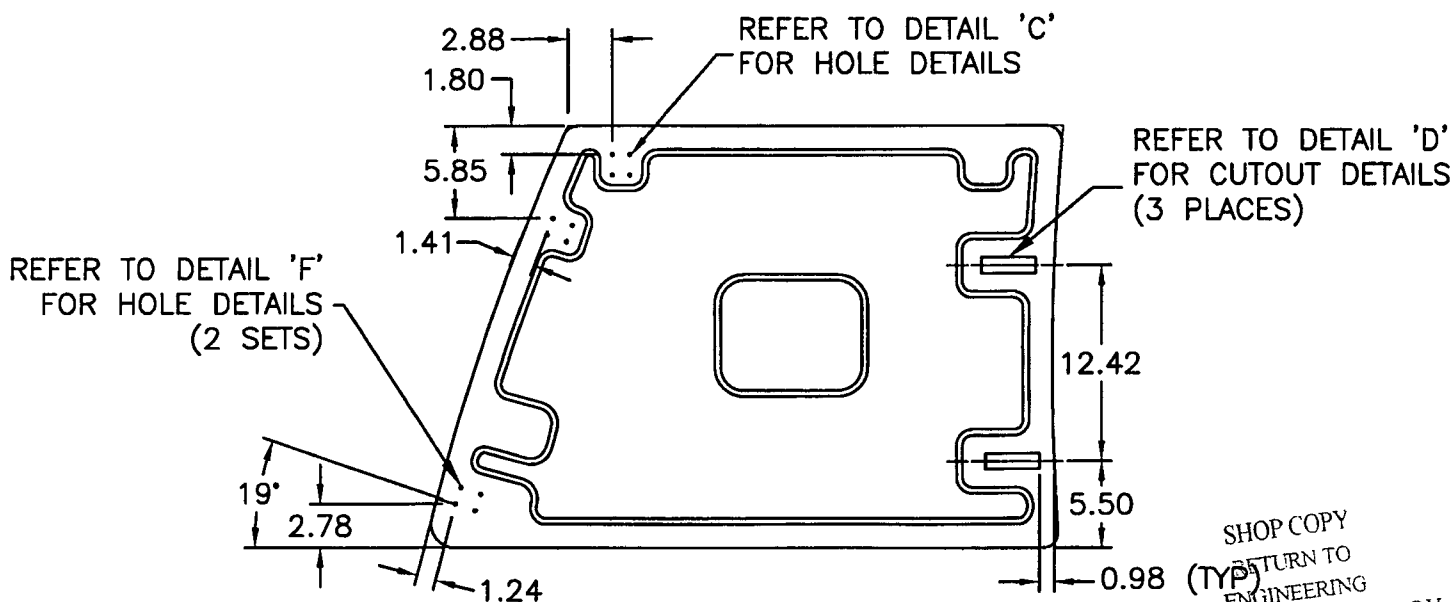
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

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D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

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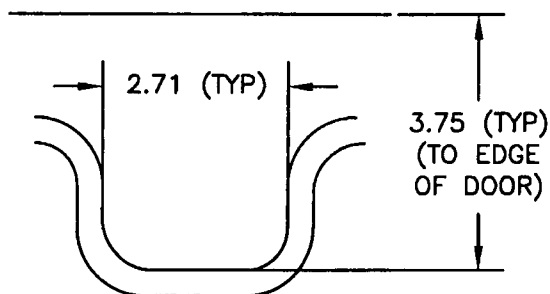
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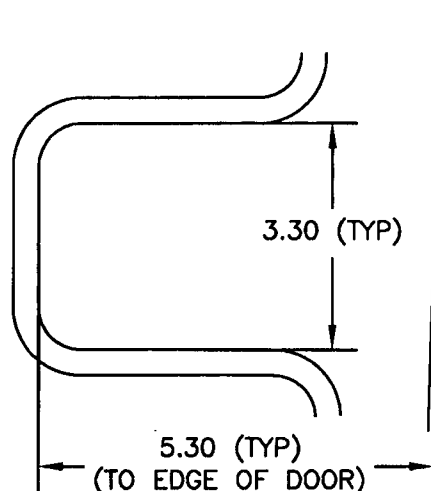
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



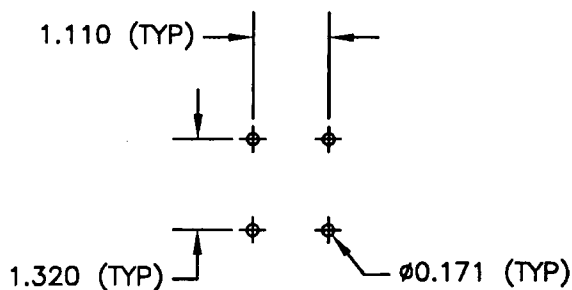
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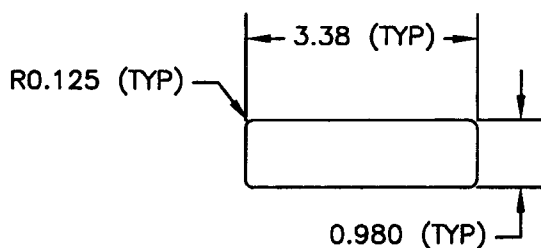
DETAIL B

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07.02.27 [Signature]

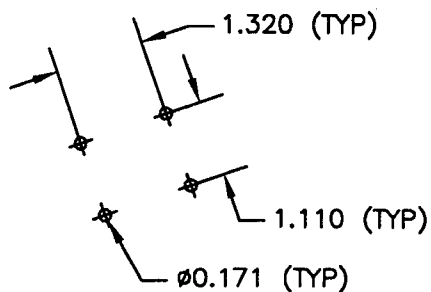


DETAIL C

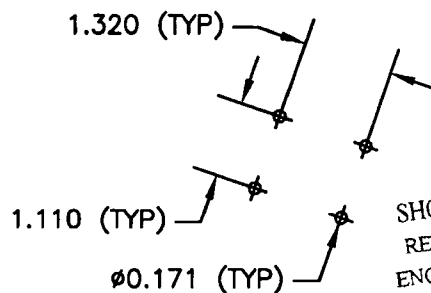


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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